



# NEXA-27

## ECONOMIC NON-MACHINABLE FERROUS ELECTRODE FOR WELDING CAST IRON.

**ALLOY BASE :** Ni.

### SPECIAL FEATURES

- Recommended for contaminated surface in old, dirty oily, greasy cast irons.
- Close colour match for cast iron.
- Economical cast iron electrode.
- Crack resistant and high tensile strength.
- Nickel free deposits
- Quick freezing.

### RECOMMENDATIONS

For all cast iron applications where machining is not required. Can be used for joining of cast iron to steel, where contaminated surface is found to be conditioned.

### APPLICATIONS

Foundry defects, sealing oil soaked cast iron. Corroded or oxidized cast iron furnace equipment, motor and generator housing. Guards on machine tools and foundry casting etc.

### PROCEDURES

Remove fatigued metal by gouging or grinding. Sue short, and skip welding sequence.Keep medium arc length and 20 mm to 60 mm long beads. Chip out the slag.

### TECHNICAL DATA

Tensile Strength : up to 60 kgf / mm<sup>2</sup>(approx.)

### CURRENT RANGE : DC (+)

SIZE mm	2.50	3.15	4.00
CURRENT (Amps)	40-70	60-110	100-150