



# NEXA-119

## EXTREMELY CRACK RESISTANT NICKEL IRON ALLOY ELECTRODE FOR WELDING CAST IRON.

**ALLOY BASE :** Ni, Fe.

### SPECIAL FEATURES

- Less base metal dilution reduced impurities impregnation.
- Very suitable for cladding.
- Excellent weld ability and high strength on most cast iron.
- Ideal for parts subjected to elevated temperature and corrosion.

### RECOMMENDATIONS

For building up missing section in all positions. Suitable for thin walled grey cast iron. Excellent for cladding repairing crack and joining of CI to other metal, good for vertical and over heat welding

### APPLICATIONS

Hot and cold welding of cast iron parts, of grey cast iron , nodular graphite iron , malleable iron subject to heavy wear. Joining of cast materials with steel. The electrode is most suitable for the surfacing of the above materials. Casting machinery parts, bearing blocks, frames, foundry casting etc.

### PROCEDURES

Sufficient amount of the casting skin should be removed. Use shortest possible arc length. The pass width should not be more than twice the diameter of the core wire. Deslag every weld bead and peen the weld metal carefully. Restrike the arc on the weld metal and never on the parent metal.

### TECHNICAL DATA

Tensile Strength : 35-45 kgf / mm<sup>2</sup>(approx.)  
Hardness : 150-190 BHN

### CURRENT RANGE : DC (+)

SIZE mm	2.50	3.15	4.00
CURRENT (Amps)	40-70	60-110	90-120