



# NEXA-242

## ELECTRODE FOR COLD WELDING OF ALL GRADES OF CAST IRON.

**ALLOY BASE :** Ni

### SPECIAL FEATURES

- Electrode with stable and soft arc, regular flow which can be used for multi position welding.
- Heat affected zone is easily machinable.
- Minimum penetration and hence very less dilution.
- No undercuts.
- Very fine and even weld ripples.

### APPLICATIONS

A versatile, nickel- based electrode for cold welding of all grades of cast iron without preheats. It is recommended for joining carbon steel to all grades of cast iron. Welds withstand server erosion and corrosion encountered in service. Best suited for repair- welding of intricate parts of cast iron, water pump housing, frame parts, cylinder block, gears, etc.

### PROCEDURES

Gouge out cracks with Nexa- 900. Grind to get even surface on groove faces. Adopt stringer bead and skip welding technique. Hot peen the deposit. Chip slag between passes. Fill craters. Allow the job to cool slowly to room temperature.

### TECHNICAL DATA

Tensile Strength : 32-38 kgf / mm<sup>2</sup>

### CURRENT RANGE (AC/DC+)

<b>SIZE mm</b>	<b>3.15</b>	<b>4.00</b>
<b>CURRENT (Amps)</b>	<b>80-100</b>	<b>100-130</b>