



Selectarc B-Fonte

Cast Iron Rod
For hot Welding

Classification

DIN 8573 : G FeC-1

ISO 1071 : R C FeC-1

Description & Applications

Welding rod for oxy- acetylene hot welding of grey cast iron. The deposit shows the same colour and structure as grey cast iron.

Mainly used to weld defects in foundries.

Base materials

Cast iron:

ASTM	DIN	NFA
A48 Class 25B – Class 60B	GG-15 to GG-40	FGL 150 to FGL 400

Typical Composition (%)

C	Si	Mn	Ni	Cu	Fe
3.3	3.2	0.5	0.5	0.1	Rem.

All Weld Metal Mechanical Properties

Hardness

~185 HB

After PWHT

Welding Instructions

Electrode	ØxL (mm)	4,0x450	5,0x450	6,0x450	8,0x450	10,0x450
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Prepare the casting defect to be repaired, preheat the piece to 550-650°C, keep this temperature during welding, cool slowly down preferable in a furnace. Use a neutral flame and a corresponding flux.

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