

Joining cast iron to steel, high welding speed**GENERAL DESCRIPTION**

Ferro-nickel electrode for joining and refacing cast iron.

Due to the high mechanical characteristics and the good resistance to cracking, Modi Lastek 47E is very suitable for welding parts with large wall thickness and for joining cast iron to steel. The high deposit rate makes this electrode especially designed to reface large sized cast iron work pieces when welded on DC plus pole (DC EP).

Good machinable deposit.

APPLICATIONS

Welding parts with high stress concentration or high strength cast iron.

Filling in blow holes in ordinary cast iron, nodular cast iron or 'Meehanite'.

Refacing cast iron dies in the car industry.

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C : 0.50 – 1.50	Si : < 1.00	Mn : 0.50 – 1.50	P & S : < 0.03	Cu : 5.00 – 8.00
Fe : 35.00 – 45.00	Ni : Balance			

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	≥ 400 MPa	≥ 20 %	

GENERAL INFORMATION

Welding positions	All		
Shielding gas	NA		
Packing	5 Kg in a plastic box		
Polarity	AC or DC, electrode either to the + or – pole (see tips & tricks)		
Diameter (mm)	2.5	3.2	4.0
Length (mm)	300	300	300

Tips & Tricks

Modi Lastek 47E can be welded either on AC or DC.

For refacing use DC + pole (DC EP).

For joining and small joints use DC - pole (DC EN).

When joining cast iron to steel, weld 2/3 on cast iron end 1/3 on steel.

The pulsating arc (when welded on DC negative) creates alternatively a heating phase (oil and dirt are burned away) and a deposit phase.

Perform a back and forward movement in the direction of the weld: phase 1 (forward) and phase 2 (back).

To avoid stress build up the weld can be hammered, certainly when welding restrained parts.

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.