

GOLD 410-E FOR COLD WELDING OF CAST IRON

Description and Applications:

Electrode for cold repair welding of most different types of cast iron.

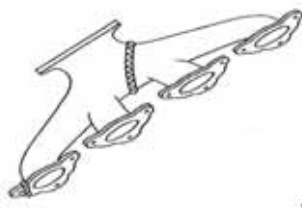
Use for welding and rebuilding of frames, gear box, machine and pump housings, engine blocks, casting defects, pulleys, compressors...

Ideal as a buffer layer when welding heavy sections with gold 420

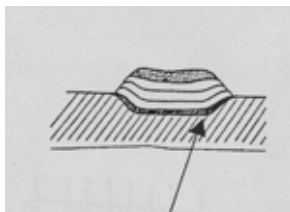
- Low heat input reduces danger of cracking
- Excellent bond on most types of cast iron
- Can be machined



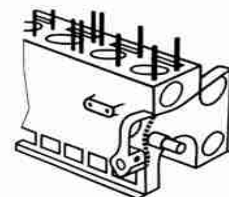
Repaired grey cast housing



Repair broken manifolds



Use as buffer layer (first layer) on difficult to weld cast iron.



Repair cracked engine blocks

Mechanical properties

Up to:

Rm (MPa)	Hardness of the deposit :	~180 HB can be machined
350		

Packaging data

Sizes	2.5x350	3.2x350	4.0x350
Kgs/Package	5	5	5
Packets/carton	4	4	4
Kgs/carton	20	20	20

Welding instructions	Current (A)	80	120	145
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Welding positions



= - ~ 40 V

Use lowest possible amperage to reduce heat input.
Apply short beads length (10 x the diameter of the electrode), peen then immediately to reduce internal stresses.
Cover welded part and allow to cool slowly.