

GOLD 420– E

FOR WELDING OF CAST IRON

Description and Applications:

High strength Fe Ni Alloy electrode for cold welding of different Cast irons such as grey cast iron nodular cast iron and for joining cast iron to steel. Electrode will not overheat and has exceptional good mechanical properties. Can also be used as a bonding layer on dirty or oily cast iron. Used for weld repairs of pump housing, machine bases, press moulds, engine blocks, flanges, foundry defects etc.

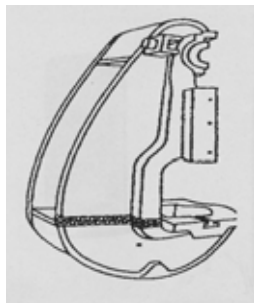
- For joining cast iron to steel
- Good machinability
- Excellent penetration (bonding) on even on contaminated surfaces
- **Hardness ~200-220 HB**



Cast iron roller repair with 420



Join Cast pipe to steel flange



Repair cracked machine bases, housings

Mechanical properties
Up to :

Rm (MPa)	Rp 0,2 (MPa)	A5 (%)
550	350	15

Packaging
Data

Sizes	2.5x350	3.2x350	4.0x350
Kg/Package	5	5	5
Packages/carton	4	4	4
Kg/carton	20	20	20

Welding instructions	Current (A)	75	115	140
----------------------	-------------	----	-----	-----

Welding positions



= +, -	~ 40 V
--------	--------