

GOLD 715-E FOR WELDING AND HARDFACING CAST IRON

Description and Applications:

Special iron based electrode **for repair welding of poor quality, slag or oil containing old cast iron** (furnace part, boxes, heaters, pumps,...
Also used for **hard facing of cast iron press tools and dies** (automotive)
Weld deposit is nickel free, has good color match and is therefore ideal for repairing foundry defects.,
-smooth arc, deep penetration
-for cast iron repair not requiring machining.



Repair old or corroded pump housing



Hard face Cast iron press tools/dies



Repair foundry defects



Weld oil impregnated cast iron (Oil sumps)

Mechanical properties

Up to :

Rm (MPa)	Rp 0,2 (MPa)	A5 (%)
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Hardness ~ 350- 400 HB

Packaging

Data

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

Welding instructions	Current (A)	75-90	85-115	100-140
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Clean weld area. Vee out cracks by using gold 110. drill holes at end of crack.

Preheat the casting to approx 100 C.

Clad the prepared surface by using a longer arc the normal.

Weld 3 to 8 cm beads only, back whipping each crate. Apply stringer beads only ,do not weave.

Remove slag between passes by chipping and brushing

Allow parts to cool slowly using available insulating material.