

AMERIARC

Ameri Cast

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.15 E NiFe-Cl
ISO 1071: E NiFe

DIN 8573: E NiFe-1 BG 21

DESCRIPTION & APPLICATION:

Ameri Cast is the high strength machinable electrode for joining, repairing & building up on cast irons. It is low amperage smooth arc minimum spatter & high resistance to cracking.

Leally suited for the repair of machine frame, engine blocks, and cylinders & joining dissimilar cast iron to steels and mild steels.

WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

C	S	Mn	P	Si	Misc	Cu	Fe	Al	Ni
1.9	.030	<2.3	--	3.8	1 MAX	2.3	<45	.97	Bal

Flux Color : Black

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	76,000 psi (525 MPa)
Yield Strength	53,000 psi (370 MPa)
Elongation	29%
Hardness	Brinell 179

WELDING CURRENT & INSTRUCTIONS:

Recommended Current : DC Reverse (+) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	50	70	100
Maximum Amperage	70	100	130

PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
	Length (mm)	12" (300)	14" (350)	14" (350)
Packaging	Electrodes / lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0