

AMERIARC

Ameri Non Machinable

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.15 EST
ISO 1071: E Fe

DIN 8573: E Fe-1

DESCRIPTION & APPLICATION:

Ameri Non Machinable welds on machine bases, furnace grates, exhaust manifolds, etc. Nickel free cast iron problem solver, seals in porosity generating contaminants prior to finish welding with nickels.

- Easily clads heat oxidized and oil impregnated castings
- Perfect color match to cast iron
- Non-conductive flux coating

WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

C	Mn	Si	S	P	Fe
.12	.58	.02	.03	.03	Bal

Flux Color : Black

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	62,000 PSI (440 MPa)
Yield Strength	50,000 PSI (360 MPa)
Elongation	20%
Hardness	Brinell 380

WELDING CURRENT & INSTRUCTIONS:

Recommended Current : DC Reverse (+), AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	45	70	95
Maximum Amperage	85	125	150

PACKAGING & DIMENSIONS:

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