



CAST IRON WELDING ELECTRODES

TECHNICAL SPECIFICATION SHEET

CAST IRON ELECTRODE

RASI CI - NM (NON MACHINABLE)

CHARACTERISTICS

RASI CI- NM is a medium heavy coated graphite based electrode which produces Non - machinable weld on Cast Iron.

APPLICATIONS

RASI CI- NM highly suitable for welding of Cast Iron, Cast Steel machine parts and equipments, where machinability of the weld is not required like general reclamation or repair work etc.

PRECAUTIONS

Ready the electrode to 150oC for one hour before use.
Use DC positive current, Short Arc, Stringer bead followed by pining.
Pre-heating is recommended for heavy and complicated sections.

**CURRENT CONDITION : AC 70 v / DC (+)
PACKING**

SIZE (MM)	2.5 x 350	3.15 x 350	4.0 x 350	5.0 x 350
CURRENT(A)	50-80	60-100	80-110	110-140
Kg/ pkt	1	1	1	1
Pkts/Box	12	12	12	12

storage - Store in warm and dry place. If damped re dry at 100-110°C for 30 minutes.

*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

www.rasielectrodes.com