



MODI XL FeNi

CAST IRON ELECTRODE

CLASSIFICATION : AWS/A 5.15 : E Ni Fe CI

CHARACTERISTICS : A nickel-iron alloy core wire electrode specially designed for producing high strength joints in malleable cast irons and in nodular cast irons. The weld metal has good ductility and machinability. Slag is very thin and runs to the sides of weld bead.

APPLICATIONS :

- Welding of all Types of Cast irons.
- Joining of Cast irons to Steels.
- Filling up Deep Cavities in Castings.
- Can be used on high Sulphur/Phosphorus Castings.

RECOMMENDATIONS : Use low currents, smallest possible size of electrode and lay small beads to avoid over heating. Peen the weld beads to reduce welding stresses. Cool the welded piece slowly under insulation. For the best result preheat the job upto 300°C.

CHEMICAL ANALYSIS OF WELD METAL (%) :

C	Si	Ni	Fe
0.8-1.50	0.9 max	55-60	40-45

HARDNESS : 220 BHN max

CURRENT CONDITIONS : USE AC OR DC (+)

Size (mm)	2.5 x 350	3.15 x 350	4.0 x 350	5.0 x 350
Range (Amps.)	40-70	70-100	100-130	130-170



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