



Characteristics and scope of application

- Filler metal for joining and overlay welding of cast iron
- Recommended for matching and dissimilar welds of cast iron and mild, stainless or heat resistant steels

Standard designations

| DIN EN ISO 1071 | AWS | DIN Mat.-No. |
|-----------------|-----|--------------|
| - | - | 2.4560 |

Typical chemical composition of filler metal

| | C | Si | Mn | P | S | Fe | Ni |
|--------|-----|-----|-----|--------|--------|------|----|
| Mass % | 0.8 | 0.1 | 0.7 | < 0.01 | < 0.01 | Bal. | 60 |

All weld metal properties (min. values at rt)

| Heat treatment | Yield strength | Tensile strength | Elongation | Impact toughness | |
|----------------|-------------------|------------------|----------------|------------------|--|
| | R _{p0.2} | R _m | A ₅ | ISO-V | |
| as welded | 290 MPa | 420 MPa | 6% | | |

Welding instructions

| Polarity | Shielding gas acc. to AWS A5.32 |
|----------|---------------------------------|
| DC / + | SG-A, M12 |
| DC / - | SG-A, SG-AHe |

Low heat input and preheating temperature according to fabrication guideslines of cast iron manufacturer. but not above 572°F. Interpass temperature approx. 90°F above preheating temperature.

| Base materials |
|---------------------------|
| EN-GJL-250. EN-GJS-350-22 |
| X120Mn12 |
| S355N/NL |

Packaging (tolerances acc. to AWS A5.02)

Approvals on request

| Diameter (in) | | lbs/PU |
|-----------------|---------------------|---------|
| 1/16 - 1/8 | x 36 in | 11 / 22 |
| 0.8 / 1.0 / 1.2 | BS 300 spool | 33 |
| 1.6 / 2.4 / 3.2 | K 415 / K 435 spool | 55 |