

**ROYAL CAST - CN (E Ni Cu - B)**AWS : E Ni Cu - B  
IS : EM Ni Cu 2/2 14**Applications**

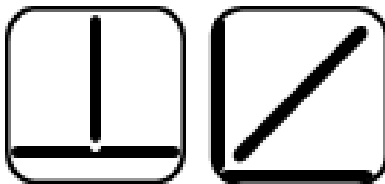
Repair of cast iron & engine blocks re-building worn surfaces joining cast iron to steel.

**Characteristics on Usage**

This is a light coated graphite based electrode for welding cast iron without preheating and for getting machinable weld on cast iron. the electrode gives a nickel copper (Monel) deposit.

**Notes On Usage**

- ✍ 1) Chip off base metal completely at the repairing part .
- ✍ 2) There is possibility that cracks spreads or makes holes at both ends of repairing part .
- ✍ 3) Keep the weld metal length less than 50 mm (2 inch ) to disperse welding heat- adopt back stepping stone or symmetry method by turns.
- ✍ 4) The preheat temperature vary in accordance with te size ,king and shape of the base metal 150°C is appropriate in general .

**Welding Positions**

1G

2F

**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Ni %	Cu %	Fe
0.70-1.30	0.60 Min	0.60 Max	0.030 Max	0.030 Max	64.0-70.0	Bal.	2.0-

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	HARDNESS
300-400	150 BHN

**Packing and Welding Current**

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 X 350	2	10	AC / DC (+)	60 - 70
3.15 X 350	2	10		70 - 100
4.00 X 350	2	10		100 – 140
5.00 X 350	2	10		

**Packing**

Vaccum packing