



SPECIFICATION OF WELDING ELECTRODE FOR CAST IRON

Specification no: CFF/M&S/C.I. W.E/01 Dt 25.05.2016

5.0 SCOPE

This specification covers the quality of electrode for shielded metal arc welding of cast iron as per AWS E Ni-Ci, SFA 5.15.

6.0 CHEMICAL COMPOSITION

<u>Element</u>	<u>Percentage (max)</u>
C	2.0
Mn	2.5
Si	4.0
S	0.03
Fe	8.0
Ni with incidental Cobalt	85.0 (min)
Cu with incidental Silver	2.5
Al	1.0
Other elements total	1.0

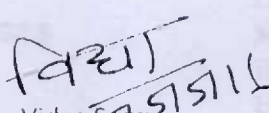
7.0 MARKING

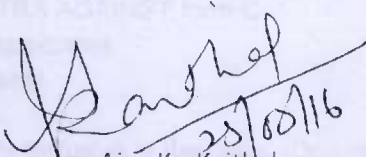
Party will print following information's on each carton:

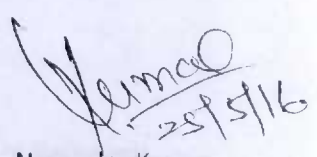
- Brand name
- Size
- Batch no. & date of manufacturing
- Quantity & net weight

8.0 ACCEPTABLE

At the option and the expense of the purchase, any or all of the test requirements of this specification may be used as a basis for acceptance of the products covered by these specifications.


Vidya Sagar
Sr.Engineer/M/c shop Maint.


Ajay Kr. Kaithal
Dy. Mgr / SF Maint & PS.


Narendra Kumar
DGM / M & S