



### 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	
	Rp0.2	R <sub>m</sub>	A <sub>5</sub>	ISO-V	
as welded	42 ksi	61 ksi	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 guidelines of cast iron manufacturer, but not above 572°F. Interpass temperature approx. 122°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
0.035 – 0.045	BS 300 spool	33
0.06 – 1/8	K 415 / K 435 spool	55