



D&H 1111CI

CODIFICATION : AWS : SFA 5.15 ENiFe-CI

CHARACTERISTICS AND APPLICATIONS :

D&H 1111 CI is an electrode depositing a ferro-nickel alloy weld metal, ideal for welding of several types of cast irons and components for producing strong crack free with good toughness weld joints. The weld deposit has good machinability and good colour match with the parent metal. It is ideally suited for joining cast iron to mild steel.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	: C	Mn	Si	Ni	Fe
Percent	: 0.90	0.70	0.90	45.0 min	Balance

TYPICAL WELD METAL HARDNESS : 190 VPN

CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	: 170-200	130-170	90-130	60-90
Weight/Carton (kgs)	: 2.5	2.5	2.5	2.5

PRECAUTIONS :

1. Ensure the electrodes are dry. In case of moisture pickup, re-dry the electrodes at 120°C for one hour.
2. Over heating of casting should be avoided by putting intermittent weld beads.
3. Allow the weld to cool slowly.