

# WELDARC

## Tubular Welding Stick Electrodes

All Position Welding including Vertical Down

## WELDARC SV CI

### FEATURES

- Conforms to AWS A5.15 ENiFe-CI.
- A Tubular Electrode with special flux having no Barium Compounds.
- Weld deposit has higher tensile strength & elongation compared to equivalent Solid Core Electrode.
- Lower co-efficient of thermal expansion.
- Weld-metal recovery is as high as 80 to 85 %.
- Sound weld –metal & good bonding on cast iron in cold condition. Specially suitable for SG, Malleable Cast Iron, Ideal for joining casting with steel & also surfacing.
- Deposit is ductile, machinable and crack- proof.
- High Deposition rate, No slag removal, Non-hygroscopic coating and No pre-drying.
- Longer shelf-life.

**TYPICAL APPLICATIONS** Repair of machine frames, bases, pump bodies, engine blocks, bearing blocks, gears and pulleys, foundry defects, transmission housing etc.

### TYPICAL MECHANICAL PROPERTIES (As Welded)

- **Tensile Strength** 49 Kgf / mm. sq.
- **Elongation** 18%

### RECOMMENDED CURRENT

DC (+) Preferred / AC 70 OCV

Size (mm)	Amps
6.30 x 450	75 to130

**IDENTIFICATION** Tip Color – SILVER

**PACKING DATA** Plastic Carton : 5 Kgs  
Card board Case : 30 Kgs.  
Pallet : 900 Kgs.

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