



FORTECAST-CN

CHARACTERISTICS :

FORTECAST-CN is a light coated electrode with graphite based coating for welding cast iron without preheating. The electrode gives a Nickel-Copper (Monel) weld deposit which is easily machinable. The electrode is suitable for welding in flat, horizontal, vertical and overhead positions. The electrode operates equally well on AC and DC. It has a soft and stable arc, easy striking and restriking properties, easy slag removal and provides good colour matching with parent metal.

APPLICATIONS:

Repair of broken castings, Filling defects in Castings, Rebuilding worn surfaces, Correcting machining errors on castings, joining cast iron to mild steel and monel overlaying on cast iron.

TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.85
Mn	2.01
Si	0.30
Ni	63.90
Fe	3.50
Cu	29.0

CLASSIFICATION :

AWS : E NiCu-B

CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC or DC (+)	Qty per Packet (kg)	Qty per Carton (kgs)
5.00x350	150-180	1	10
4.00x350	120-150	1	10
3.15x350	80-120	1	10
2.50x350	50-70	1	10



FORTECAST-N

CHARACTERISTICS :

FORTECAST-N is a light coated electrode depositing pure nickel, designed for welding cast iron in the cold way. The nickel weld deposit which bonds thoroughly with the cast iron, is soft and ductile and can be easily machined or filed to desired shape. The tensile strength of the weld metal is adequate for cast iron. Its main characteristics are stable and quiet arc, negligible spatter, easy and intimate fusion and easy striking/restriking.

APPLICATIONS :

Pump cases, Impellers, Gears, Sprockets, Engine heads, Rope drums, Machine bodies, CI dies, Correcting of machining errors on castings. Joining all kinds of Cast iron, Cast iron to steel, Monel, Copper or Copper alloys. For building up noncorrosive surface of Nickel on Cast iron parts.

TYPICAL WELDMETAL COMPOSITION:

Element	Percent
C	1.35
Mn	2.00
Si	2.70
Ni	91.67

CLASSIFICATION :

AWS : E NiCl

CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC or DC (+)	Qty per Packet (kg)	Qty per Carton (kgs)
5.00x350	140-160	1	10
4.00x350	100-120	1	10
3.15x350	70-90	1	10
2.50x350	40-60	1	10





FORTECAST-FN

CHARACTERISTICS :

FORTECAST-FN is a light coated electrode designed to weld all weldable cast irons. The weld metal is fully machinable and has good colour match with the parent metal. The weldmetal contains 55% Ni, has good strength, toughness and is crack resistant. The electrode has a soft and stable arc, easy slag removal and good striking/restriking properties.

APPLICATIONS :

Welding of all types of Cast iron, Rectification of defects in Heavy castings, Correcting machining errors on Castings, Joining Cast Iron to Mild Steel, rebuilding work surfaces.

TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	1.43
Mn	2.30
Si	1.85
Ni	51.29
Fe	43.00

CLASSIFICATION :

AWS : E Ni Fe-CI

CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC or DC (+)	Qty per Packet (kg)	Qty per Carton (kgs)
5.00x350	130-170	1	10
4.00x350	90-120	1	10
3.15x350	70-110	1	10
2.50x350	40-70	1	10



FORTECAST-NM

CHARACTERISTICS :

FORTECAST-NM is a heavy coated, all position, low hydrogen type electrode for welding of medium high tensile structural steels, joining and surfacing of high strength steels such as carbon steel & also cast steels. It produces high purity, radiographic quality non machinable weld deposits.

APPLICATIONS :

Welding of cast iron parts, cast steels, cast iron to mild steel & all types of general reclamation work.

TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.085
Mn	1.10
Si	0.57
S	0.017
P	0.022

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength Kg/mm2	Yield Strength Kg/mm2	Elongation % (L=5d)	CVN Impact Strength at 20 °C. Kgm
57	48	26	8

CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC (70V) or DC (+)	Pieces per Packet	Pieces per Carton
6.30x450	250-360	30	120
5.00x450	190-240	45	180
4.00x450	140-190	80	320
3.15x450	100-140-	110	440
2.50x350	60-90	160	640

