



**Shri Balaji Alloys  
Corporation India**



# MAXIDURA - CI 114

EXTREAMLY CRACK RESISTANT NICKEL ALLOY ELECTRODE FOR WELDING CAST IRON

## ALLOY BASIS

Fe, Ni

## PROPERTIES

Electrode with excellent welding characteristics. The deposit is machinable and crack proof. Good bonding on difficult to weld cast iron. Ideal for CI to MS welding and CI to CI Welding.

## TECHNICAL DATA

Hardness - 135-218

UTS of joint(all weld deposit) : 35-45Kgf/mm

## TYPICAL APPLICATIONS

Hot and Cold welding of cast iron parts of gray cast iron, nodular graphite iron, malleable iron subject to heavy wear. Joining of cast material with steel. The electrode is most suitable for the surface of above material. Casting, Machinery parts, bearing blocks, frames, foundry casting etc.

## WELDING CURRENT

<b>CURRENT</b>	:	<b>AC/DC(+)</b>		
Size (mm)/Length	:	3.15×350	4.0×350	5.0×350
Current (amps)	:	70-90	90-140	130-180

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