



**Shri Balaji Alloys
Corporation India**



MAXIDURA - CI 116

Welding high-strength and heat-resistant cast irons.

ALLOY BASIS

Cr, Ni

PROPERTIES

A graphite type coated electrode, depositing weld metal consisting of almost nickel. Hard ending of the weld metal and fusion zone in cast iron is smallest and machining of the welds is comparatively easy. Therefore, it is suitable for welding alloy cast iron of poor weld ability, malleable cast iron and hydraulically pressured parts as well as common cast iron.

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

CURRENT	:	AC/DC(+)		
Size (mm)/Length	:	3.15×350	4.0×350	5.0×350
Current (amps)	:	80-130	400-160	1500-210

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