



M-90 ESt

FEATURES

- *SHIELDED METAL ARC WELDING OF CAST IRON METAL
- *NON-MACHINABLE
- *SEMI MACHINABLE AND NON MACHINABLE TYPES

APPLICATION

- *Repairing of cast iron**

CLASSIFICATION

- *A5.15/ ASME SFA5.15 ESt

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Fe	MO
2.47	0.41	0.45	0.024	0.024	0.0	97.6	

HARDNESS

Hardness (HRB)
450-510

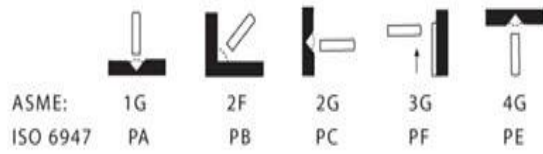
WELDING PARAMETERS

DIAMETER (mm)	2.5	3.2	4
LENGTH (mm)	350	350	350
CURRENT (amps)	60-90	80-130	110-160

CURRENT

*AC or DC +/-

WELDING POSITIONS



Current

= +	~	(U ₀ :60V)
-----	---	-----------------------