

**CI MATCH COMP FeC**

This electrode gives a weld deposit similar in composition to grey cast iron but with slightly raised silicon content to enhance graphite formation. Colour match and weathering behaviour are much closer to the base material than conventional high nickel weld metals. As-deposited hardness will vary with cooling rate which is controlled by appropriate preheat. A

preheat above 400°C and up to 600°C may be necessary to match base material hardness. A non-machinable deposit is obtained without preheat. Main application is to repair defects in new castings of known pedigree. It is also used for general casting repairs where the necessary procedural controls can be applied.

**CLASSIFICATION - MIG**

DIN 8573 EFeC-2-BG3

The nearest AWS A5.15 Est is based on steel core wire but the deposit composition is not defined as matching cast iron.

**CHEMICAL ANALYSIS**

% Carbon	2.700	% Chromium	0.010
% Manganese	0.300	% Nickel	0.500
% Silicon	4.500	% Molybdenum	<0.01
% Sulphur	0.010	% Copper	0.030

**TYPICAL MECHANICAL PROPERTIES  
(ALL WELD METAL IN THE AS WELDED  
CONDITION)**

Hardness without preheat will typically exceed 350HV. Softest and easily machined deposits of around 150HV are obtained with 500-600°C preheat. A higher hardness obtained with intermediate preheat can be useful for resistance to abrasion and friction. Redry 200-250°C for 1-2 hrs.

**PACKING DATA**

(DC+ or AC (OCV 70V Min))

Diameter (mm)	Amps	Item Number	Pack Mass (Kg)
2.50	70 - 115	078-110	3.7
3.20	90 - 155	078-112	4.2
4.00	130 - 210	078-114	4.2

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