

SMAW Electrodes – Cast Iron

GCI-3

AWS A5.15 ESt
ISO 1071-ECSt 1
JIS Z 3252 ECSt N

Product Features:

- Low hydrogen Graphite type covered electrode for cast iron welding and repair.
- Using GC100 or GC55 for first layer, GCI-3 for the others to save cost.

Applications:

- Suitable for cast iron welding and repair welding under high temperature and non-post machining required condition.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	P	S	Fe
0.07	0.02	0.44	0.016	0.006	Bal.

Typical mechanical properties of all-weld metal

Hardness HV
440

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.6/300	3.2/350	4.0/350/400	5.0/450
Flat position	60-90	90~130	110-160	150~220

Note:

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