



**DATA SHEET
DS 241
Rev. 00 dd 03/12/2013
INE GHISA**

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CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
	EN ISO 1071: E C Fe1

APPROVALS

ALLOY TYPE

Graphite-coated electrode for cold welding of cast iron.

APPLICATIONS

Graphite-coated electrode with iron core designed for cold welding of cast iron and for repairs of poor quality welding. It is used in some parts of heaters, pumps, etc. which containing old cast iron. Intended for all positions; the weld deposit can be machined by grinding.

MATERIALS TO BE WELDED

ASTM		EN		Others

WELDING GUIDELINES

Preheat and PWHT are not required. Use a low amperage, maintain the arc short, deposit thin layers.

TECHNICAL INFORMATION

Welding positions: all positions



WELDING PARAMETERS

Current	AC / DC - (+) Straight polarity					
Diameter (mm)	2.5					
Length (mm)	300					
Intensity (A)	50 ÷ 90					



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TYPICAL CHEMICAL COMPOSITION OF WELD METAL

C %	Mn %	Si %	S %	P %	Ni %	Fe %			
0.50	0.80	0.20	0.015	0.015	0.10	Bal.			

TYPICAL MECHANICAL PROPERTIES

	Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
	Rs	Rm	A 5d	+20°C	0°C	-20°C	-40°C	-60°C
	(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
as welded	-	-	-	-	-	-	-	-

PRODUCTS AVAILABLE

Process	Product	Classification AWS	Classification EN
MIG/MAG			
Solid wire			
TIG			
Rods			
SAW			
Submerged arc			
FCAW			
Cored wire			
SMAW			
Electrodes			