

## PRODUCT INFORMATION

### SIF SUPER SG CAST IRON

[Proprietary]

This rod is suitable for full fusion oxy-acetylene welding of Spheroidal Graphite cast iron, providing a machinable weld and a good colour match. Use with SIF CAST IRON flux for best results when oxy/acetylene welding.

### WELDING POSITIONS



Suitable for use in the manufacture or repair of components made from Spheroidal Graphite cast iron.

### TYPICAL WELD METAL COMPOSITION

C	3.7 %
Si	2.5 %
Mn	0.1 %

### TYPICAL MECHANICAL PROPERTIES

Melting Point	1440 °C
Ult Tensile Strength	650 N/mm <sup>2</sup>
Hardness	180

### MATERIAL TO BE WELDED

Can be used to join castings, building up worn parts surfacing new castings and for the repair of all Spheroidal Graphite cast iron products. Some pre-heating may be required before welding. This rod is cast in a square section and available in a choice of two diameters.

### AVAILABLE FORMATS

SPOOLED WIRE (MIG / GMAW)	
Dia	5.0kg Ctn
6.0mm	RO296050
10.0mm	RO291050

Gas Welding – Oxy / Acetylene

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email **service@wholeweld.co.uk**

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