

Electrode for Direct Overlaying on Cast Irons (TIG Welding)

G N — V 5 T

■ Tip Color —

■ Application

Overlaying and repair welding of cavities and cracks on cast irons.

■ Features

1. GN-V5T is Fe base electrode for direct overlaying on cast iron for TIG welding. Also Fe base deposited metal mixes with the cast iron base metal smoothly.
2. GN-V5T is suitable for joint welding and repairing crack or defects of the cast iron base metal. Also it is good for underlaying of hardfacing on the cast iron.
3. The deposited metal shows almost same color tone as cast iron.

■ Welding Procedures

1. In general, preheating and post heating are not required but depending upon the type, shape or size of the base metal, preheating at 100~200°C causes good welding result.
2. To prevent crack at the welded junction between the base metal and the weld metal, shallow penetration in first layer applying low electric current and short arc is recommended.

■ Typical Chemical Components of the Electrode

C—Si—Mn—Special Elements

■ Typical Hardness of the Deposited Metal as welded

HV	HRB	HS
150~200	78~91	22~29

■ Dimensions

Diameter (mm)	Length (mm)	Minimum Quantity (Kg)
1.6 2.0 2.6 3.2	1,000	5

Equivalent to electrode for shielded metal arc welding: GN-V5

Equivalent to wire for MAG welding: GRIDUCT S-V5