



PHILARK PH 100

Coated Electrode for Cast Iron



General Description

A pure nickel, non-conductive flux coating electrode for repair and maintenance welding of cast iron components. PHILARK PH 100 exhibits excellent arc characteristics by producing a drop arc transfer which assists in combating surface contamination such as when joining badly oiled cast iron parts. For all types of machinable repairs on old, contaminated, oil-soaked gray and alloyed castings. Sound, dense deposits are fully machinable. It can be used for thin, as well as thick sections.

Crack resistance									
Bonding									
Machinability									

Mechanical Properties of Weld Metal

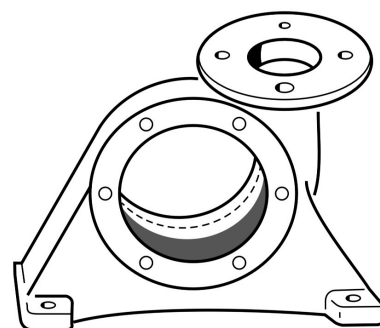
Tensile Strength : 28 - 35 kg/mm²

Elongation (L=5d) : 10-15 %

Hardness : 110-150 HB

Typical Applications

- Pump housings
- Pump rotors
- Compressors
- Valves
- Gear boxes
- Engine blocks
- Cylinder heads and blocks
- Pulleys
- Eccentric wheels



Cast Iron Valve Seats

Welding Parameters

Current Type and Polarity : AC/DC(-)

Diameter [mm]	2.50	3.15	4.0
Length [mm]	350	350	350
Current [A]	70-90	100-120	130-150

