



PHILARK PH 2278

Bi Metal Ferro Nickel Electrode for Cast Iron



General Description

PHILARK PH 2278 is a specially designed electrode that offers good weldability, high tensile strength, ductility and machinability joining of cast iron and cast iron to steel of similar / dissimilar thicknesses. Repair welding of high strength, heavy duty ductile irons involving massive section and for joints under restraints.

Crack resistance	
Bonding	
Machinability	

Mechanical Properties of Weld Metal

Tensile Strength : 78,000 psi
Yield Strength : 55,000 psi
Elongation : 30%
Hardness : 86-88 HRB

Typical Applications

- For joining low carbon steel alloys or any grade of weldable cast iron to itself.
- Special "Bi-Metal" core Ferro Nickel electrode with exceptionally powerful arc thrust to pierce impurities.
- Exceptionally strong arc drive makes joining in any position possible.
- Great performance on low-quality porous castings; complete elimination of electrode overheating due to high efficiency weld metal transfer.



Welded DI Flange Pipe

Welding Parameters

Current Type and Polarity : AC/DC(-)

Diameter [mm]	2.50	3.15	4.0
Length [mm]	350	350	350
Current [A]	50-70	70-100	100-130

PHILARK ALLOYS

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