



## PHILARK PH 10

*Coated Electrode for Cast Iron*



### General Description

PHILARK PH 10 is a economical welding electrode for welding cast iron parts when machining is unnecessary. The welded joint can be ground. It has good color matching, penetration and excellent weldability. PH 10 is used especially on poorly weldable cast iron such as burnt and bad castings and for buffering the sides of the seam. It is also suited for wear resistant build up on solid castings.

Crack resistance					
Bonding					
Machinability					

### Mechanical Properties of Weld Metal

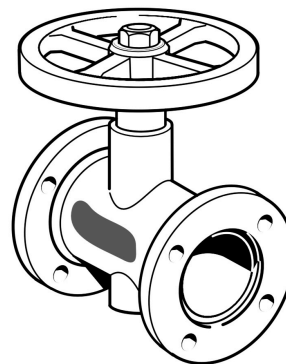
Tensile Strength : 50 - 55 kg/mm<sup>2</sup>

Elongation (L=5d) : 28 %

Hardness : 35-40 HRC

### Typical Applications

- Repair of cast iron not requiring machining
- All types of sections, thick or thin
- Joining Cast iron to steel



Cast Iron Valve Bodies

### Welding Parameters

Current Type and Polarity : AC/DC(+)

Diameter [ mm ]	2.50	3.15	4.0
Length [ mm ]	350	350	350
Current [ A ]	80-90	100-110	120-140

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