



## PHILARK PH 50

*Coated Electrode for Cast Iron*



### General Description

PHILARK PH 50 has high nickel content, barium free Electrode. It is recommended for cold welding of all types of cast irons where watertightness and/or 100% machinability are required. The coated is non-conductive.

### Mechanical Properties of Weld Metal

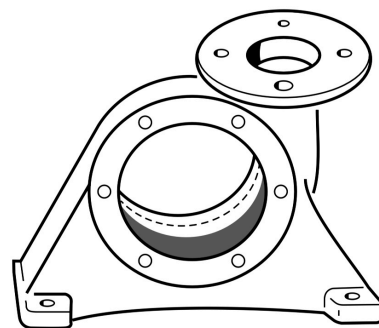
Tensile Strength : 36 - 40 kg/mm<sup>2</sup>

Hardness : 70-75 HRB

### Typical Applications

- Cold welding of Cast irons of thin to avg. thickness.
- Dissimilar Assemblies (Cast Iron/steel)
- Engine Blocks
- Pump impellers
- cylinder heads
- Sleeves
- Machining Errors
- Gear Boxes
- Full machinability

Crack resistance									
Bonding									
Machinability									



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 ]	70-90	105-115	130-145

PHILARK ALLOYS

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