



## PHILARK PH 50 S

*Coated Electrode for Cast Iron*



### General Description

PHILARK PH 50 S has Ni-Cu alloyed deposit and it has been specially designed for welding of malleable cast iron and nodular or ductile spheroidal graphite iron where ease of welding, low heat input and high crack resistance are important. Therefore, it is very suitable for making thick joints and for filling up deep cavities. It has high crack resistant deposits which are fully machinable. It can be used on both heavy and thin sections, especially for welding in position. The special arc characteristics also allow welding even on contaminated surfaces. It is also suitable for joining cast iron to steel. The deposit is the optimum colour match with the cast iron parts..

Crack resistance	██████████
Bonding	██████████
Machinability	██████████

### Mechanical Properties of Weld Metal

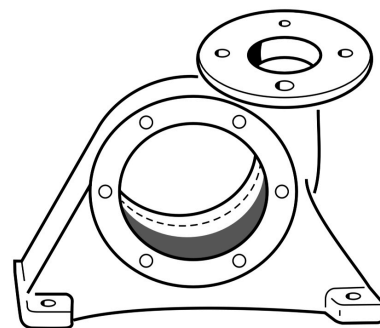
Tensile Strength : 38 - 44 kg/mm<sup>2</sup>

Elongation (L=5d) : 15-20 %

Hardness : 140-180 HB

### Typical Applications

- Repair of nodular and ductile iron castings and foundry defects
- Machine housings
- Pipes and flanges
- Pump impellers
- Pulleys
- Gears and gear boxes
- Turbine blades
- Engine blocks
- Transmission housings
- Joining of grey cast iron to steels and stainless steels.
- Joining of steels to copper alloys



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 ]	50-60	60-85	85-110

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