

## AI-0440

### Specifications

**DIN 8573 : E FeCG13**

### Description and Applications

Basic coated electrode for hot welding of nodular cast iron. **AI-0440** is also suitable for welding malleable black heart cast iron, as well as common grey cast iron, provided heat treatment is applied. An excellent alloy for sealing of dirty or contaminated cast iron prior to joining using **AI-0412**, **AI-0420** or **AI-0435**.

### Typical Weldmetal Analysis

C	Si	Fe
3050	3.70	Bal

### Mechanical Properties of Weldmetal

	As Welded
Hardness:	200HB

### Welding Parameters

Diameter (mm)	Current type	Amps
3.2	DC /AC	80-120
4.0	DC /AC	120-140

### Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position

### Disclaimer

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