

# VALIANT

## VALIANTWELD-NM

AWS:A5.15:EST

Valiantweld- NM is an all position cast iron electrodes depositing air hardening type for non machinable cast Iron and joining with mild steel and low alloy steels where 160-250 Brinell hardness is required, Welds are normally non machinable, crack resistant and free from porosity.

### CHEMICAL COMPOSITION

C	Mn	Si	Cr	Ni	Fe
2.5	1.5	1.5	15.6	1.0	Balance

### MECHANICAL PROPERTIES

TYPICAL WELD METAL HARDNESS
160-250HV

### WELDING PARAMETERS

	Size (mm)	Current (Amp.)
AC/DC (-)	4.00 X 350	110-150
	3.15 X 350	70-110
	2.50 X 350	50-70

### APPLICATION

Ideally suited for joining and repair welding/ maintenance of cast iron.

#### INDIA

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