

<b>International standards</b>	DIN 8573	E FeC-2-BG 11
	AWS A 5.15	ESt
	DIN EN ISO 1071	E C FeC - GF 1

**Approvals** ---

**Typical applications and characteristics** **CARBO GG** is a special basic graphite coated stick electrode for the welding of cast iron. It is used for the repair welding of difficult to weld, heavily contaminated and poor quality cast iron. It is also suitable for wear resistant overlays on cast iron parts.  
The weld deposit of only machinable by grinding. It is a good colour match with the base material and can be enamel coated.  
The electrode has a soft, spatter-free running characteristic, with good penetration and an easily removable slag.

**Operating temperature** same as base material

**Welding recommendations** The weld area should be thoroughly cleaned. The weld groove should be made to allow a sufficient gap between the two surfaces of the casting (prepare using CARBO NUT)  
Depending on the base material pre-heat up to 600°C and after welding cool slowly (retaining wrap).  
The electrode is also suitable for positional welding.

<b>Weld metal analysis</b> (typical, wt. %)	<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Ti</b>	<b>Fe</b>
	1,70	1,20	0,90	+	bal.

**Current** = + / - , ~ / 50 V

**Welding positions** PA, PB, PC, PE,

**Rebaking** 1 h, 120 °C + / - 10 °C (if required)

<b>Dia./Length</b>	<b>Amperage (A)</b>	<b>Pcs./box</b>	<b>Pcs./carton</b>	<b>kg/1000</b>	<b>kg/box</b>	<b>kg/carton</b>
2,0 x 300	40 - 60	417	1668	9,6	4,0	16,0
2,5 x 350	50 - 80	286	1144	17,5	5,0	20,0
3,2 x 350	60 - 110	169	676	29,6	5,0	20,0
4,0 x 350	80 - 140	110	440	44,9	6,0	24,0
5,0 x 450	110 - 170	67	268	90,2	6,0	24,0

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