

Cast iron												
Type / code	Covered electrodes											
	-	-	-	-	-	-	-	-	-	-	-	-
Filler metal	E 46 4 B 32 H5	E FeC-2-BG 11	E Ni-BG 11	E NiFe-1-BG 11	E NiFe-1-BG 11	E NiFe-1-BG 11	E NiFe-1-BG 11	E NiCu-BG 21				
	CARBO MN B	CARBO GG	CARBO Ni 2	CARBO NiFe 31	CARBO NiFe 60/40	CARBO NiFe 60/40 K	CARBO NiCu					
Base metal												
Lamellar graphite cast iron after EN 1561 (DIN 1691)												
JL1010	GJL-100 (GG-10)			●				③				
JL2010	GJL-HB155 (GG-150HB)			●				③				
JL1020	GJL-150 (GG-15)			●				③				
JL2020	GJL-HB175 (GG-170HB)			●				③				
JL1030	GJL-200 (GG-20)			●				③				
JL2030	GJL-HB195 (GG-190HB)			●				③				
JL1040	GJL-250 (GG-25)			●				③				
JL2040	GJL-HB215 (GG-220HB)			●				③				
JL1050	GJL-300 (GG-30)			●				③				
JL2050	GJL-HB235 (GG-240HB)			●				③				
JL1060	GJL-350 (GG-35)			●				③				
JL2060	GJL-HB255 (GG-260HB)			●				③				
Ductile cast iron (Sphäroguß) in accordance to EN 1563 (DIN 1693)												
JL1015	GJS-350-22LT (GGG-35.3)		●		●	●	●	③				
JS1030	GJS-400-15 (GGG-40)		●		●	●	●	③				
JS1025	GJS-400-18-LT (GGG-40.3)		●		●	●	●	③				
JS1050	GJS-500-7 (GGG-50)		●		①	①	①	③				
JS1060	GJS-600-3 (GGG-60)		●		①	①	①	③				
JS1070	GJS-700-2 (GGG-70)		①		①	①	①	③				
JS1080	GJS-800-2 (GGG-80)		①		①	①	①	③				
White malleable iron Temperguß (decarborised glowed) in accordance to EN 1562 (DIN 1662)												
JM1010	GJMW-350-4 (GTW-35-04)	②	②		●							
JM1020	GJMW-360-12W (GTW-S 38-12)	●	●	●								
JM1030	GJMW-400-5 (GTW-40-05)	②	②	●								
JM1040	GJMW-450-7 (GTW-45-07)	②	②	①								
Black malleable iron (not decarborised glowed) in accordance to EN 1562 (DIN 1692)												
JM1130	GJMB-350-10 (GTS-35-10)			●	●	●	●	③				
JM1140	GJMB-450-6 (GTS-45-06)			①	①	①	①	③				
JM1160	GJMB-550-4 (GTS-55-04)			①	①	①	①	③				
JM1180	GJMB-650-2 (GTS-65-02)			①	①	①	①	③				
JM1190	GJMB-700-2 (GTS-70-02)			①	①	①	①	③				

- very suitable
- ① suitable, (take into account strength requirements).
- ② suitable, for up to 0.3% C in the joint area without preheating and post heat treatment.
- ③ suitable, for fill and cap pass after root pass with other types often good colored match.