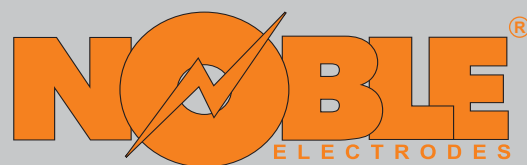


NOBLE- NM

Mild Steel Cast Iron Electrodes



Characteristics : **NOBLE - NM** is a medium coated high strength electrode for non-machinable welds on cast iron. It is useful when a strong and rigid joint is to be obtained between two cast iron parts. Pre-heating of base metal is recommended up to 400°C for heavy and complicated sections.

Applications : **NOBLE - NM** is suitable for the welding of cast iron parts like gears, motor Housing etc. For all types of reclamation or repair work, where machinability is not required and joining cast iron to mild steel.

Mechanical Properties

| Mechanical Tests | Required Values |
|------------------|-----------------|
| Hardness | 300 – 400 (BHN) |

Weld Metal Chemistry (%)

| Elements | C | Mn | Si | P |
|----------|-------------|-------------|-------------|-----------|
| Range | 1.50 - 2.75 | 0.35 - 0.80 | 0.30 - 0.70 | 0.040 Max |

Packing Specifications & Current Condition

| Size (mm) | Pkts. / Case | Pcs. / Pkt. | Current (Amp.) AC (70 V), DC (+) |
|------------|--------------|-------------|-------------------------------------|
| 3.15 x 350 | 12 | 90 | 100 - 140 |
| 4.00 x 350 | 08 | 60 | 130 - 180 |

“Noble – Characterized by all Excellent Qualities”