

# Cast Iron Welding Electrodes

These welding electrodes are designed for cast iron materials. They are available in non-machinable and machinable types, including pure nickel and nickel55% variations.

WELDING ELECTRODE		WELDING ELECTRODE	
CAST IRON WELDING ELECTRODES			
Electrode	Core	Flux	Notes
ENiCrFe	ENiCrFe	Graphite	For cast iron repair and maintenance applications. Suitable for all positions.
ENiCrFeMn	ENiCrFeMn	Graphite	For cast iron repair and maintenance applications. Suitable for all positions.
ENiCrFeMnNi	ENiCrFeMnNi	Graphite	For cast iron repair and maintenance applications. Suitable for all positions.
ENiCrFeMnNiCu	ENiCrFeMnNiCu	Graphite	For cast iron repair and maintenance applications. Suitable for all positions.
ENiCrFeMnNiCuMn	ENiCrFeMnNiCuMn	Graphite	For cast iron repair and maintenance applications. Suitable for all positions.
ENiCrFeMnNiCuMnNi	ENiCrFeMnNiCuMnNi	Graphite	For cast iron repair and maintenance applications. Suitable for all positions.
ENiCrFeMnNiCuMnNiCu	ENiCrFeMnNiCuMnNiCu	Graphite	For cast iron repair and maintenance applications. Suitable for all positions.
ENiCrFeMnNiCuMnNiCuMn	ENiCrFeMnNiCuMnNiCuMn	Graphite	For cast iron repair and maintenance applications. Suitable for all positions.
ENiCrFeMnNiCuMnNiCuMnNi	ENiCrFeMnNiCuMnNiCuMnNi	Graphite	For cast iron repair and maintenance applications. Suitable for all positions.
ENiCrFeMnNiCuMnNiCuMnNiCuMn	ENiCrFeMnNiCuMnNiCuMnNiCuMn	Graphite	For cast iron repair and maintenance applications. Suitable for all positions.

## ADDITIONAL IMAGES



## Product Overview

### Professional Cast Iron Welding Solutions

These cast iron welding electrodes are engineered for high-performance repair and maintenance applications. Available in three distinct formulations—Oxide flux with carbon steel core, Graphite with pure nickel core, and Graphite with nickel/ferro core—they cater to diverse industrial requirements. Designed for versatility, these electrodes support welding in all positions (F, V, OH, H) and are compatible with both AC and DC+ current, ensuring reliable, durable joints across various grades of cast iron.

## Technical Specifications

### Current Type

AC • DC+

### Welding Positions

F, V, OH, H

### Packaging

10kg net cartons (1kg x 10 plastic boxes)

# Electrode Types

## WELDING ELECTRODE

## WELDING ELECTRODE



### CAST IRON WELDING ELECTRODES

Type of Coating	Cast Iron Welding Electrode (Model No.)	Equivalent Specification	Welding Position	Type of current	Standard & Typical Chemical Composition							of Deposited Metal (%)			Application
					C	Mn	Si	P	Cr	Ni	Cu	Fe	Rem		
Oxide flux with carbon steel core	MT-Z208	AWS E8	F, V, OH, H	AC or DC+	≤0.15	≤0.60	≤0.15	≤0.040	≤0.040	-	-	-	-	Rem	Repair welding defects of normal cast iron and old steel ingot mold used over a long period of time, non-machinable.
Graphite with pure nickel core	MT-Z308	AWS ENi-CI	F, V, OH, H	AC or DC+	≤2.00	≤2.50	≤4.0	≤0.050	-	-	≥85	-	≤8.0	Rem	Repair welding of various kinds of cast iron products. Deposits nearly pure nickel which is easy machinable.
Graphite with nickel-ferro core	MT-Z408	AWS ENiFe-CI	F, V, OH, H	AC or DC+	≤2.00	≤1.80	≤2.50	≤0.050	-	-	45-60	-	Rem	Repair welding of important grey iron casting and nodular iron casting. Also for welding mild steel to all grades of cast iron.	

Packing: In cartons of 10kgs net each, consisting of 1kgs x 10 plastic boxes.



Technical overview of welding electrode specifications, including chemical composition and application guidance.

## Electrode Type Comparison

Model	AWS Equivalent	Core/Flux Type	Primary Application
MT-Z208	ESt	Oxide flux / Carbon steel	Repairing normal cast iron/steel ingot molds (non-machinable)
MT-Z308	ENi-CI	Graphite / Pure nickel	Repairing various cast iron (easy machinable)
MT-Z408	ENiFe-CI	Graphite / Nickel-ferro	Grey/nodular iron casting; welding mild steel to cast iron