ARC WELDING ELECTRODES

MAINTENANCE & REPAIRS
CAST IRON & COPPER ALLOYS

www.selectarc.com
# STEEL

| **48 SP**  | Universal rutile all position electrode.  
| **48 SP**  | Easy striking.  
| **48 SP**  | Exceptional handling.  
| **48 SP**  | *Recommended for poor quality steels.* |

| **B 7016 SP**  | Universal double coated basic electrode for all applications on highly stressed connections.  
| **B 7016 SP**  | Easy striking.  
| **B 7016 SP**  | Exceptional handling.  
| **B 7016 SP**  | Stable arc in all positions.  
| **B 7016 SP**  | *Recommended for root passes and on badly prepared joints.* |

| **B 70**  | Basic coated electrode highly resistant to cracking for high security welds and repairs.  
| **B 70**  | Few spatters, smooth fusion.  
| **B 70**  | Easy slag removal. |

| **CUT 100**  | Cutting and piercing all metals and alloys.  
| **CUT 100**  | *Removing weld beads or bolt heads.* |

# CAST IRON

| **FONTE Ni**  | Welding all grey cast iron types without preheating.  
| **FONTE Ni**  | Also suitable for combined welding with electrode FERRO Ni.  
| **FONTE Ni**  | *Repairing engine blocks, tool machine housings,*  
| **FONTE Ni**  | *exhaust pipes, castings, pump bodies,*  
| **FONTE Ni**  | *reducers, valve bodies, etc.* |

| **FONTE Ni3**  | Application identical to FONTE Ni with *nonconductive coating.*  
| **FONTE Ni3**  | Prevents side arcing while in contact with the workpiece. |

| **FERRO Ni**  | Universal electrode for cold welding GS cast iron.  
| **FERRO Ni**  | Also suitable for welding cast iron to steel.  
| **FERRO Ni**  | Good mechanical characteristics.  
| **FERRO Ni**  | Machinable deposit.  
| **FERRO Ni**  | *Foundry defects, repairing engine blocks, reducers,*  
| **FERRO Ni**  | *gearboxes, pump bodies, castings,*  
| **FERRO Ni**  | *flywheels, tool machine housings, etc.* |

| **FeNiCu**  | Application identical to FERRO Ni with copper coated core wire for increased electrical conductivity.  
| **FeNiCu**  | No overheating, excellent handling. |

| **Bimétal-NiFe**  | Bi-metal core wire electrode with high thermal and electrical conductivity for high fusion speeds.  
| **Bimétal-NiFe**  | Adapted for direct current and alternating current.  
| **Bimétal-NiFe**  | High mechanical characteristics for welding and repairing cast irons subjected to severe stress.  
| **Bimétal-NiFe**  | *Poor quality cast irons, foundry defects, machine housings, etc.* |

| **FONTE-Fe**  | Used for underlaying or anchoring contaminated cast irons on small surfaces.  
| **FONTE-Fe**  | Repairing minor foundry defects.  
| **FONTE-Fe**  | Colour match with base metal. |
## STAINLESS STEEL

<table>
<thead>
<tr>
<th>Code</th>
<th>Type Description</th>
<th>Details</th>
</tr>
</thead>
<tbody>
<tr>
<td>20/10 MBC (E 316L-16)</td>
<td>Electrode for welding all types of common construction stainless steels 308 L, 316 L. Stainless steels for the food industry, tanks, piping systems, shipbuilding equipment, containers, etc.</td>
<td></td>
</tr>
<tr>
<td>24/12 MO (E 309MoL-16)</td>
<td>Electrode with a deposit containing low carbon austenitic steel highly resistant to cracking. High resistance to corrosion. Dissimilar joints (stainless steel to steels), plated steels, etc.</td>
<td></td>
</tr>
<tr>
<td>29/9 (E 312-17)</td>
<td>Universal electrode for high security maintenance welding and repairing all types of construction steels, tool steels, spring steels, heat-treated steels and all types of stainless steels. Dissimilar joints. Buffer layering before hardfacing.</td>
<td></td>
</tr>
<tr>
<td>312 HR (E 312-26)</td>
<td>High efficiency (160%) synthetic electrode with an application identical to electrode 29/9. Particularly recommended for welding galvanized steels.</td>
<td></td>
</tr>
<tr>
<td>25/20 R (E 310-16)</td>
<td>Electrode with a deposit containing high temperature stainless steel for maintenance welding and repairing parts subjected to temperatures up to 1150°C. Hearths, rollers, sliding guides, oven bells, boilers, heat-treat ovens, oil and petrochemical industries, etc.</td>
<td></td>
</tr>
</tbody>
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## NICKEL BASE

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</tr>
</thead>
<tbody>
<tr>
<td>Ni 182 (E NiCrFe-3)</td>
<td>“Inconel 600” ** electrode with a nickel base deposit for welding and repairing parts subjected to temperatures and corrosion. Cast steels, chemical and petrochemical industries, furnace rollers and roller guides, civil engineering, etc.</td>
<td></td>
</tr>
<tr>
<td>B 90 (E NiCrFe-3)</td>
<td>Electrode with a nickel base deposit especially designed for maintenance welding and repairing very difficult to weld steels. Resistant to temperatures and corrosion. Dissimilar joints, castings, oven rollers and bands, transportation and storage of liquid gas, etc.</td>
<td></td>
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</tbody>
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* “Creusabro” is a trademark of CREUSOT LOIRE.
** “Inconel” is a trademark of INCO.
### COPPER

**CU 114**  
(E CuSn-A)  
Basic coated electrode for welding and repairing bronze (6-8% tin) and brass alloys and other similar alloys.  
Adapted for welding with direct current and alternating current.  
*Shipbuilding, foundries, propellers, shafts, bushings, pump rotors, valve seats, turbines, shoes, etc.*

**CU 116**  
(E CuAl-A2)  
Basic coated electrode for welding and overlaying CuAl alloys as well as dissimilar joints (steel to copper alloys).  
*Shipbuilding, cast irons, alloy steels, parts attacked by salt water, propellers, propeller shafts, bearings, bushings, chemical industry, etc.*

**CU 118**  
(E CuMnNiAl)  
Basic coated electrode for welding and overlaying bronze and CuAl alloys as well as dissimilar joints (steel to copper alloys).  
*Anti-friction properties for hardfacing sliding guides, bearings, shaft surfaces, bushings, etc.*

### ALUMINIUM

**AL 105**  
(E 4043)  
Aluminum electrode for maintenance welding and repairing aluminum parts and aluminum alloys.  
*Casting alloys, engine blocks, cylinder heads, tanks, containers, lorry tippers, shipbuilding, chemical industry, etc.*

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For your hardfacing work, consult our “HARDFACING” pamphlet.

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...as well as a full range for your specific applications.  
Consult us.