Eutectrode Castolin 2-26 D



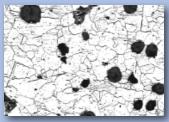


- · Developed for manufacturing, repair and construction welding
- Meets wind turbine requirement standards
- Notch impact strength at -20 ° C higher than 10 joules

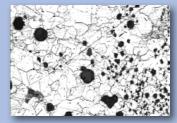


ELECTRODO CASTOLIN 2-26 D

Micrographs of a hot welded SG cast iron







Transition zone



Weld metal

Cast iron hot welding

The MMA EutecTrode 2-26 D for cast iron hot welding has been specially adapted to the needs and requirements of wind turbine components. The main objective was to achieve a notch bar impact value of > 10 joules at -20 ° C. The ideal matching of the flux coating formulation around the core rod ensures this requirement. This has been verified in studies by an independent testing laboratory.

Applications

For matching types of manufacturing, engineering and repair welding (cast iron hot welding) of grey cast irons with Spheroidal or Nodular Graphite as well as cast iron with flake graphite. Also for reclamation of casting defects like blowholes. **Examples:**

- Turbine housing
- Engine and gearbox housing
- Valve housing
- Rotor housing, etc.

Matching type of cast iron hot welding

For cast iron hot welding, the complete component must be slowly preheated to 550 °C to 700 °C, once the weld zone has been suitably prepared. After welding, the post-weld heat treatment is performed depending on the base material. The hot welding of cast iron is always recommended if mechanical properties, machinability and colour of the weld metal must reasonably match those of the cast iron work-piece. Also recommended when distortion, deformation or surface oxidation are justifiable up to certain tolerances

Electrodo Castolin 2-2 DIN EN ISO 1071: AWS A5.15:	26 D E C FeC ECI	
Weld metal (untreated)		Values determined for pure weld metal
Yield point R _{p0,2}	[MPa]	~ 325
Tensile strength R _m	[MPa]	~ 435
Elongation A ₅	[%]	~ 12
Notch impact value	-20 °C [J]	> 10
Diameter	[mm]	4 und 6

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Prüfber Test-Report for	richt für Werkst	offe		Prüf-Nr.: Test-No.:	12	2 10 206 \$
Auftraggeber: Orderer	Castolin GmbH Gutenbergstr. 10 65830 Kriftel			Auftrags-Nr.: Order-No.: Kunden-Nr.:	DEK003715 027936	
Werkstoff:	Castolin 2-26D			Abnahmeges.:		
Werkstoff-Nr:	-			Anlage zu :		
Norm:	Castolin					
Specification:	Kundenvorschrift					
Specification Prüfnormen: Test specification	Kundenvorschrift DIN EN 875					
Specification Prüfnormen:	Kundenvorschrift	Dir	ssungen	Schmelze Heat	Stück-Nr.	IdNr.
Specification: Prüfnormen: 7est specification Anzahl	Kundenvorschrift DIN EN 875 Gegenstand Object Probestück / Test piece.	D x B	ssungen			ld. No.
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Prüfnormen: Test specification Anzahl Navnter 1	Kundenvorschrift DIN EN 875 Gegenstand Object Probestick / Test piece Hersteller Macubet O. A. / not mentioned	D x B 35 x	x L [mm] 30 x 200	Lieferzustand	Piece No. 2-26D gem. Hersteller	Id. No.
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Prüfnormen: Test specification Anzahl Namber 1 Bernerkungen: Freesurs Kerbschla Impact test et ver Probenform Type of seasone	Kundenvorschrift DIN EN 875 Gegenstand Oxed Probestlick / Test plece Hersteller John Control Control Schweidgulgerübe Gussessen Si geliegeversuch an Sender John En 875 : Charpy-V Temp. (*C) Inte 670 mile	abelektrode Castolin Chweißverbir Dicke [mm]: Trickness [mm] EW1 [J]	2-260 idungen ge	Lieferzustand Delvery condition 0. A. / not	Pece No. 2-26D gem. Hersteller acc to mensificativer mentioned	J0350 / 1

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