

Finalloy

FINALLOY ACI 224 AC-DC (Reverse)

NICKEL - FREE, NON-MACHINABLE CAST IRON PROBLEM SOLVER.

SPECIAL FEATURES



- ▶ PERFECT COLOUR MATCH TO CAST IRON
- ▶ NON-CONDUCTIVE FLUX COATING
- ▶ EASILY PENETRATES HEAT OXIDIZED AND OIL IMPREGNATED CASTINGS
- ▶ ALL POSITION WELDING

MECHANICAL PROPERTIES for ACI 224

APPLICATIONS

- For non-machinable welds on machine bases, furnace grates, exhaust manifolds, etc.,

Undiluted Weld Metal	Maximum Value upto :
Tensile Strength	62,000 psi (44kgs/mm ²)
Yield Strength	50,000 psi (36kgs/mm ²)
Elongation %	20 %
Hardness	Rockwell C39, Brinell 380

INTERNATIONAL
SPECIFICATIONS

AWS/ASME E St
DIN 8573: E FeS1

WELD METAL ANALYSIS (Typical Weight %) for ACI 224

C	Mn	Si	S	P	Fe
.12	.58	.02	.03	.03	Bal

Flux Colour - Black

Product of USA

Finalloy
The
FINAL welding solution