

Non-Machinable Cast Iron Problem Solver

STARBLAZE CI NM

- ★ Uniquely welds cast iron that is greasy, rusty & burnt where other electrodes will not bond.
- ★ “Fast freeze” action minimises weld defects & porosity.
- ★ Color & co-efficient of expansion closely matches cast iron to ensure a professional finish.
- ★ Excellent positional welding.
- ★ Welds successfully without preheat.



Description and applications

Nickel free non-machinable cast iron problem solver, seals in porosity generating contaminants prior to finish welding with nickels. Superior alloy for dirty or burned cast iron.

Furnace gates, oil saturated cast iron, foundry casting repairs, steel to cast iron welding, Underlaying /anchoring contaminated cast iron.

All weld metal Mechanical Properties (Typical)

Yield strength R_p (N/mm ²)	Tensile strength R_m (N/mm ²)	Elongation A_5 (%)	Hardness (HRc)
≥360	≥500	≥18	38 – 42

Amperes (A)

3.15mm	3.20mm	4.00mm	5.00mm
90-120	90-120	120-160	160-220

Welding instruction Keep dry and avoid condensation. Redry electrodes at 200°C for 1 hour.

Welding Positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850

Plant 1: A-125, Okhla Industrial Area, Phase 2, New Delhi - 110020

Corporate Office & Plant 2: 552, Pace City II, Sector 37, Gurugram, Haryana - 122001

Plant 3: B-100, Mayapuri Industrial Area, Phase-1, Near Police Station, New Delhi-110064

Plant 4: A-334, RIICO Industrial Area, Karoli, Bhiwadi, Rajasthan - 301707

Tel: +91 124 4499523 | Email: sales@starblazeindia.com | Website: www.starblazeindia.com