



# S. R. Industries

## STAR ARC EST

*Castarc (ESt) is a nickel free cast iron problem solving electrode. It seals in porosity generating contaminants prior to finish welding with nickels. This is a great choice for non-machinable welds on machine bases, furnace grates and exhaust manifolds. This alloy has a perfect color match to cast iron.*

### Specifications :

<i>AWS Specification</i>	<i>A5.15</i>
<i>AWS Classification</i>	<i>ESt</i>
<i>Welding Current</i>	<i>DCEP</i>
<i>Typical Wire</i>	<i>Chemistry</i>
<i>C</i>	<i>0.15</i>
<i>Mn</i>	<i>0.60</i>
<i>Si</i>	<i>0.15</i>
<i>S</i>	<i>0.04</i>
<i>P</i>	<i>0.04</i>
<i>Fe</i>	<i>REM</i>
<b><i>Typical Mechanical Properties (As Welded)</i></b>	
<i>Yield Strength, ksi</i>	<i>50</i>
<i>Tensile Strength, ksi</i>	<i>62</i>
<i>Elongation%, min</i>	<i>20</i>
<i>Brinell Hardness</i>	<i>250 - 400</i>
<i>Welding Positions</i>	<i>F, V, OH, H</i>
<b><i>Available Diameters and suggested Operating Range in Amps</i></b>	
<i>3/32"</i>	<i>45- 85</i>

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<i>1/8"</i>	<i>70- 125</i>
<i>5/32"</i>	<i>95- 150</i>

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