

Standards

TS 9463 EN ISO 1071	: E C NiCu-B1
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AWS A5.15	: ~ E NiCu B

**Chemical Composition of
Weld Metal % (Typical)**

Ni	Cu
~ 68.0	~30.0

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (L ₀ =5d ₀) (%)	Hardness (HB)
min. 190	300	min. 15	~140

Features and Applications

- Soft joint welding of grey cast iron
- Filler welding, repair welding and gently striking the bead of each pass with a hammer when the bead is hot are required
- Ni-Cu cored stick electrode

Welding Positions

Current Type

D.C.(-) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101704	2.50 x 300	3/32 x 12"	60 - 90	1850
3010101711	3.20 x 300	1/8 x 12"	90 - 110	2860
3010101718	4.00 x 400	5/32 x 16"	110 - 130	5790

Approvals: CE, SEPRO, TSE