

**Standards**

TS 9463 EN ISO 1071	: E C Ni-Cl 1
EN ISO 1071	: E C Ni-Cl 1
AWS A5.15	: E Ni-Cl

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

C	Ni
0.5	rest

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)	Hardness (HB)
200	250	3	~170

**Features and Applications**

- Joint welding of grey cast iron, temper cast iron, nodular cast iron as well as joint welding of cast iron with steel, stainless steel and Monel metal
- Ni cored stick electrode
- Welding in short passes, and gently striking the bead of each pass with a hammer when the bead is hot are required

**Welding Positions**

**Current Type**

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

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101623	2.50 x 300	3/32 x 12"	60- 90	1860
3010101630	3.20 x 300	1/8 x 12"	90-110	2880
3010101644	4.00 x 400	5/32 x 16"	110-130	6070

**Approvals:** CE, SEPRO, TSE