

Standards

TS 9463 EN ISO 1071	: E C Ni-CI 3
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AWS A5.15	: E Ni-CI

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

Fe	Ni
7.0	rest

Mechanical Properties

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

Features and Applications

- Ni cored stick electrode
- Welding in short passes, and gently, striking the bead of each pass with a hammer when the bead is hot
- Joint welding of grey cast iron, temper cast iron, nodular cast iron and joint welding of cast iron with steel
- Weld metal recovery of approx. 110%

Welding Positions

Current Type

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

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101674	4.00 x 400	5/32 x 16"	110 - 140	6820

Approvals: CE, SEPRO