

Standards

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

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

C	Ni
0.5	min. 96

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

- Non-conductive, basic-graphite-coated nickel stick electrode
- Repair welding of problematic cast iron parts of irregular shapes
- Joint welding of cast iron parts, and cast iron parts to steel parts
- Pre-heating to 200 °C is recommended for thick- walled components
- Welding in short runs, and peening are required

Welding Positions

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101651	2.50 x 300	3/32 x 12"	70 - 100	1950
3010101658	3.20 x 300	1/8 x 12"	90 - 110	2940
3010101665	4.00 x 400	5/32 x 16"	110 - 130	5250

Approvals: CE, SEPRO, TSE