

### Standards

TS 9463 EN ISO 1071	: E C Ni-CI 1
EN ISO 1011	: E C Ni-CI 1
AWS A5.15	: E Ni-CI

### Mechanical Properties

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation ( $L_0=5d_0$ ) (%)	Hardness (HB)
285	335	min. 5	~180

### Features and Applications

- Barium free (contain minimal emission for the environment), Non-conductive (better safety), basic graphite coated electrode with a nickel core wire
- 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 preening are required

### Welding Positions



### Current Type

D.C.(+)

### Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3030100009	3.20 x 300	1/8 x 12"	100 - 130	2840

Approvals: CE, SEPRO