

Standards

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

Mechanical Properties

Tensile Strength (N/mm ²)	Elongation ($L_0=5d_0$) (%)	Hardness (HB)
240-300	min. 5	~170 HB

Features and Applications

- Low-heat-input manual electrode for joining old cast iron
- Electrode with pure nickel core for assembly and suriacing of broken or worn parts made of grey cast iron, also for reclamation of casting defects and for welding grey cast iron to steel
- Ni-cast electrode can be machinable by cutting tools
- Before welding large sections, preheating is useful
- Depending on quality of cast iron post weld may be needed
- Ensure that all areas to be welded are free from contaminant, remove casting defects such as sand inclusions, oil, damages of fatigue base material
- Controllable weld pool, excellent bonding, easy slag removal, dense, homogeneous and porosity-free deposit

Welding Positions



Current Type

D.C.(-)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Package Weight (Kg)	Weight g / 100 pcs
3030100004	2.50 x 300	3/32 x 12"	60 - 90	5	1830
3030100006	3.20 x 300	1/8 x 12"	90 - 120	5	2840
3030100008	4.00 x 350	5/32 x 14"	120 - 150	5	5150