



CASTNICKEL

CAST IRON



High Nickel Electrode for Repair and Welding of Cast Iron The Cold Way

CLASSIFICATION : ISO 1071

AWS A/SFA 5.15

NiCl 1

E Ni-Cl

KEY FEATURES :

- Graphite based coating
- High Ni alloyed electrode
- Minimum base metal dilution and penetration
- Electrode welds cast iron the cold way
- Soft, ductile and machinable weld with adequate strength
- No need of preheating even for large complicated castings
- Easy and intimated fusion with all grades of cast iron

WELDING POSITION :



AC (45 OCV)/ DCEP

TYPICAL APPLICATIONS :

- Repair of broken heavy castings, machine bases, motor blocks, sprockets, valve bodies, impellers, pump casting and gears
- Joining and build up of grey cast iron and malleable iron
- Joining cast iron to steel
- Correcting machining errors on castings
- Suitable for thin walled grey cast iron
- Sliding tables for machine tools
- Building up on cast iron parts exposed to corrosive liquids

REDRYING CONDITION : 150°C for 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Ni	Fe	Mn	Si	S	Cu	Al
Typical	1.2	91.5	3.0	1.0	2.0	0.02	0.7	0.5
Specification	2.0 max	85.0 min	8.0 max	2.5 max	4.0 max	0.03 max	2.5 max	1.0 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	3 Layer, Hardness, BHN
Specification	As Welded	140-180

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg
2.5 x 300	45-65	1	10	10
3.15 x 300	70-90	1	10	10
4.0 x 300	100-120	1	10	10