

# CASTNICKEL

AWS A/SFA 5.15 ENi-CI

## CAST IRON

### CLASSIFICATION:

ISO 1071  
E C Ni-CI 1

IS 5511  
E Ni G23

### 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

**APPROVALS:** CE

### 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



### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Fe	Ni	Cu	Al
0.6	0.2	0.4	2.3	96	0.007	0.009

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	3 Layer, Hardness, BHN
Specification	As Welded	180 max

### PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 2.5 x 350 3.15 x 350 4.0 x 350	<b>Amperage, A</b> 45-65 70-90 100-120	 <b>AC (70 OCV)/ DCEP</b> <b>REDRYING CONDITION:</b> 150°C for 1 hr.	All Positions, except vertical Downwards 
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Available in Standard carton packing of 10 kg box containing 1 cartons of 10 kgs each.