



CASTNICKEL

CAST IRON

AWS A/SFA 5.15 ENi-CI

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


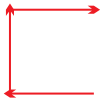
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Fe	Ni
0.6	0.2	0.4	2.3	96

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS, MPa	EL, %	Hardness, BHN
Specification	As Welded	276-448	262-414	3-6	135-218

PARAMETERS - PACKING DATA:

Ø x L, mm 2.5 x 350 3.15 x 350 4.0 x 350	Amperage, A	 AC (70 OCV)/ DCEP All Positions, except vertical Down 
	45-65	
	70-90	
	100-120	REDRYING CONDITION: 150°C for 1 hr.

Available in Standard carton packing of 10 kg box containing 1 cartons of 10 kg each.