



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

CLASSIFICATION : AWS A/SFA 5.15

E Ni-CI

### 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. (Also available in vacuum packed condition)

### 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