CASTNICKEL

CLASSIFICATIONS

AWS A/SFA 5.15 ENi CI

IDENTIFICATION: Name Printed

CHARACTERISTICS

An electrode with pure nickel core wire specially designed for welding cast iron the cold way. The nickel deposit does not pick up carbon from the base metal and hence remains ductile, soft and easily machinable and at the same time retains adequate strength. This enables successful use of the electrode without the necessity of preheating even on large complicated castings.

CURRENT CONDITIONS: AC, DC

4.0	3.2	2.5
100-120	70-90	45-65

WELDING POSITIONS

F & H Fillet

REDRYING CONDITIONS

150^{0}C for 1 hour (Optionally also available in vacuum-packed condition)

TYPICAL APPLICATIONS

Easy and intimated fusion with all grades of cast iron, the electrode is best suited for welding and repairing all cast iron components. Excellent for building up a noncorrosive surface of nickel on cast iron parts exposed to corrosive liquids. Successful applications include repair of broken castings, building up or worn surface or correcting machining errors on castings and joining cast iron to steel.

WELD METAL CHEMISTRY, (%)		
C - 2.0 max.	Cu - 2.5 max.	S - 0.03 max.
Mn - 1.0-2.5	Ni - 85.0 min.	Fe - 8.00 max.
Al - 1.0 max.	Si - 4.0 max.	

PACKING DATA			
Dia., mm	4.0	3.2	2.5
Length, mm	300	300	300
Wt. per carton, kg	1	1	1
Cartons / box	10	10	10
Net wt per box, kg	10	10	10

MECHANICAL PROPERTIES - ALL-WELD	
Condition	**Hardness** BHN
As-welded	140-180