



Pure Ni – Electrode for MMA welding of Cast Iron

Graphite based, Barium free, pure Nickel Electrode for the joining ordinary Gray Cast irons to join themselves or to other ferrous and non-ferrous materials and reclaim or repair castings used for maximum machinability only. May also be used for Malleable or Ductile Irons.

International Standards

EN ISO 1071:2003	AWS A5.15 - 90
E C Ni-CI	E Ni-CI

Typical All-Weld Metal Analysis (wt%)

C	Si	Ni	Fe
0.6	0.50	Balance	6.00

Typical All-Weld Metal Mechanical Properties

Tensile Strength N/mm ²	Hardness HB
>300	170

Welding Positions

All positions except, vertical down

Materials

Joining Gray Cast Irons to themselves or to other ferrous and non ferrous materials and reclaim or repair casting used for maximum machinability only.
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Packaging

Size mm	2.5 x 350	3.2 x 350	4.0 x 350
Pieces/Package	125	80	60
Kg/Package	2.5	2.5	2.5

Operating Requirements

DC+ AC (40ocv min)	80 A	110 A	140 A
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Notes

Ensure the removal of all defects, machine or grind to sound metal. For all welding without preheat the temperature during welding should not exceed 100°C (hand hot) and deposit small welds at low currents without weaving. Cooling should be slow and even throughout.
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