

# CAST Ni

## Electrode depositing pure Nickel for machinable welding of cast Iron.

**CLASSIFICATION** : AWS/SFA-5.15: E Ni Cl  
DIN E NiG3

**APPROVAL** :

**CHARACTERISTICS** : A light coated electrode depositing pure Nickel in weld metal to work on cold conditions without pre-heating the jobs. The nickel content in weld metal deposit allows to achieving a soft and tough weld. The tensile strength is good enough to match parent metals tensile strength. Deposits are machinable.

**APPLICATION** :

- 1) Suitable to weld carbon steel to cast iron.
- 2) Repairs on cast iron castings.
- 3) Filling up casting defects.
- 4) Building up worn out surfaces.
- 5) Engine blocks, pump casing, impellers, Gears and valve bodies.

**RE-DRY CONDITION** : Re-Dry the electrode at 150°C for 1 hour.

**WELDING PRECUATIONS** :

1. clean the weld area free of any surface contaminations.
2. Bevel broken part or cracks to 70-80° Vee.
3. Use the short arc and as possible as low current.
4. preheat the part, if necessary.

### ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	Fe
1.20 Max	1.00 Max	1.00 max	96 Min	Bal.

### WELD METAL HARDNESS:

Hardness
140-160 VPN

### DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/ AC) Amps	Wt. of /pkt.	Wt. of Case
2.50/ 2.40 X 350	3/ 32" X 14"	60-80	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	80-110	2	20
4.00 X 350	5/ 32" X 14"	110-130	2	20
5.00 X 350	3/ 16" X 14"	140-180	2	20

Customer packing on request.