

CLASSIFICATION

AWS/A 5.15 : E Ni Cl

CHARACTERISTICS

A pure Nickel core wire electrode designed for welding of cast iron with minimum or no pre heat. Weld metal is very soft but tough and easy machinable. Globular metal transfer and low penetration are some special features.

APPLICATIONS

Reclamation of defective castings, joining of Cast Iron to Steel Monel and Copper, filling up small cavities, repair of damaged/cracked castings.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

| Carbon | Manganese | Nickel | Iron |
|--------|-----------|--------|------|
| 1.30 | 0.30 | 94.08 | 4.02 |

HARDNESS: 200 BHN Max

CURRENT RANGE & PACKING DATA:

| Size (mm) | Length (mm) | Current(Amp) AC or DC(+) | Quantity of Electrodes in a Carton | Quantity of Electrodes in a Cardboard box |
|-----------|-------------|-----------------------------|--|---|
| 2.50 | 350 | 40-70 | 2 Kg | 10 Kg |
| 3.15 | 350 | 70-100 | 2 Kg | 10 Kg |
| 4.00 | 350 | 100-130 | 2 Kg | 10 Kg |
| 5.00 | 350 | 130-170 | 2 Kg | 10 Kg |

RECOMMENDATIONS:

Select the small size of electrode. Use low current and deposit thin layer to avoid overheating. Peen the welds for reducing the stresses. Cool the welded part under insulation.