

Ni(-)

CATEGORY SMAW Stick Electrodes

TYPE Special coated electrode for welding cast iron with a pure nickel core wire.

APPLICATIONS Joining and cladding grey and malleable cast iron, also suitable for joint welds between steel , copper and copper alloys, especially for maintenance and repair.

PROPERTIES Excellent welding properties with easily controllable flow permits spatter free welding with very low current. Due to the very low heat input and unique composition of Ni(-) the transition zone will stay well machinable and is therefore well suited to use as first layer in case off multi-layer welding. The weld metal will show no undercut !
Preheating is normally done to slow down the cooling speed, in case you can not control the cooling speed it is better to keep the work peace at a low temperature during welding and hammer immediately after welding.

CLASSIFICATION

AWS	A 5.15: E Ni-C1
EN ISO	1071: E C Ni-CI1
DIN	1736: E Ni-BG 22

SUITABLE FOR Grey cast iron, Malleable cast iron, EN 1561: EN-GJL-100 (GG10) till EN-GJL-350 (GG35), EN 1562: EN-GJMB-350 (GTS 35) till EN-GJMB-550 (GTS 55), EN- GJMW-350 (GTW 35) till EN- GJMW-550 (GTW 55).

APPROVALS CE approved

WELDING POSITIONS:



C	Mn	Si	Cr	Ni	Mo
				98	

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW		240-290					160

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
2.5	350	60-80	3.5	21	19.4
3.2	350	80-110	3.5	21	32.8
4.0	350	110-140	3.5	21	48.7
5.0	450	140-170			98.1

REDRYING TEMPERATURE 200°C / 1hr