

ENi-CI

AWS A5.15 ENi-CI
GB/T10044 EZNi-1

Description:

A pure nickel electrode designed to weld normal grades cast irons. The weld metal is soft and easily machinable, deposition is performed on cold or slightly preheated material. It is suitable for joining cast irons for the rectification of casting and repairing of broken parts. Used to weld thin parts of cast irons and repair broken parts.

Welding Position:



Diameters:

2.5mm, 3.2mm, 4.0mm, 5.0mm.

Typical Chemical Composition:

C	Mn	Si	S	Fe	Ni	others
≤2.0	≤1.0	≤2.5	≤0.03	≤8.0	≥90	≤1.0

Welding Current:(AC/DC+)

Diameter(mm)	2,5	3,2	4,0	5,0
Current/A	-	95-120	150-180	190-220

Note:

- 1.The electrodes must be baked 1 hours in 150℃ before using.
- 2.Hammer the bead can relieve strength of weld parts to avoid crack..