

ERNi-CI

AWS A5.15 ERNi-CI

Description:

ERNi-CI is corrosion-resistant alloy with nominally 99% Nickel, which is used for welding of cast irons to other cast irons as well as for joining cast irons to mild steels and stainless steels. Readily used for the repair of castings. The wire will deposit welds that are machine-able.

Diameters:

1.2/1.6mm

Typical Mechanical Properties:

Tensile strength(MPa):	448
Yield strength(MPa):	255
Elongation(%):	27
Impact values(≥ 47)/(-20 °C):	—

Typical Chemical Composition:

C	Mn	P	S	Si	Ni	Cu	Mg	Co
0.01	0.25	0.006	0.003	0.05	96.1	0.13	0.01	2.12

Welding Current:(DC+)

Diameter(mm)	1.2	1.6
Current/A	75-160	120-300
Voltage/V	19-22	20-32
Gas speed/(L/Min)	20-25	20-25

Note:

- 1, Rusty, water, oil and other impurity should be cleaned before welding.
- 2, Use 75% Ar+25% He as shielding gas