

EZCuNi-1

AWS A5.15 EZCuNi-1

Description:

EZCuNi-1 is Ni-Cu alloy core, graphite type coating type cast iron electrodes used to repair grey cast iron with not-so-high strength.

Welding Position:



Diameters:

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

Typical Chemical Composition:

C	Mn	Si	S	Cu	Ni	Fe
0.38	1.98	0.55	0.003	0.01	64.5	4.2

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 weld bead once after welding