

# ENI-CI

CAST IRON WELDING ELECTRODE  
WITH MACHINABLE WELD, N199

**TecMig**  
The pro's choice

ISO 9001  
CERTIFIED

## CHARACTERISTICS

1. Graphite based coating and high Nickel alloyed electrode
3. Minimum base metal dilution and penetration
4. Soft, ductile and machinable weld with adequate strength
5. No need of preheating even for large complicated castings
6. Easy and intimated fusion with all grades of cast iron

SIZE	AMPS
2.5mm	40-70A
3.2mm	70-110A
4.0mm	90-120A

## CLASSIFICATION

AWS A5.15 ENI-CI  
EN ISO 1071 E C Ni-CI

## PACKING SPECIFICATION

1kg Vacuum Pack with Plastic Tube

## CURRENT TYPE

AC/DC+

## AVAILABLE SIZES (DIA./LENGTH)

2.5mm\*350mm  
3.2mm\*350mm  
4.0mm\*400mm

## EQUIVALENT TO

Lincoln RepTec Cast 1  
Esab OK 92.18  
Hyundai S-NCI  
Kiswel KSN-100

## TYPICAL APPLICATIONS

1. Repair of broken heavy castings, machine bases, motor blocks, sprockets, valve bodies, impellers, pump casting and gears
2. Joining and build up of grey cast iron and malleable iron
3. Joining cast iron to steel
4. Correcting machining errors on castings
5. Suitable for thin walled grey cast iron
6. Sliding tables for machine tools
7. Building up on cast iron parts exposed to corrosive liquids

## CHEMICAL COMPOSTIONS (Wt%), ALL WELD METAL, TYPICAL

C	Fe	Ni
0.7	1.5	95.0

## MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

Condition	0.2% Proof Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Hardness (HB10)
AW	375	405	5	185

### Note:

- ① Residual stresses are decreased by peening after each layer.
- ② Cold welding, interpass temperature <100°C.
- ③ Heavy parts preheat (to max. 300°C).

