



Nickel Electrode for Welding Cast Iron AWS – ASTM - ENiCI

AC or DC REVERSE (ELECTRODE+)

GENERAL CHARACTERISTICS:

A high nickel content electrode with an extruded coating for welding cast iron. Welds are easily produced in all positions and the deposits are readily machined.

APPLICATIONS:

Used to join ordinary gray irons to themselves or to other ferrous and non-ferrous materials. Also for repair of castings when matching is to be done after welding. Welds can be satisfactorily produced on light and medium-size castings if there are not severe stresses or high phosphorus content encountered in the parent material.

TECHNICAL DATA:

| | | | | |
|--------------------------------------|---|--------|---------|---------|
| Specifications | AWS A5.15 class ENi-CI | | | |
| | ASTM A398 class ENi-CI | | | |
| Nominal Chemical Composition % | Ni95.0, C-1.00, Mn-0.20, Fe-3.0, S-0.005, Si-0.70, Cu-0.10 | | | |
| Current | AC or DC Reverse Polarity (Electrode+) | | | |
| Amperage | 40-75 | 65-115 | 100-150 | 120-175 |
| (in) | 3/32 | 1/8 | 5/32 | 3/16 |
| (mm) | 2.5 | 3.25 | 4.0 | 5.0 |

PROCEDURES:

In most cases, preheating or post-heating will not be necessary but in cold weather or when special machining qualities are desired, the part should be preheated to 400° F (204° C). Stringer beads and intermittent welds should be employed to reduce stresses and cracks; peening while still hot also helps reduce these problems. Allow part to cool slowly.

Manufactured by **AmAlloy Industries®**

To Order - Call: **800-735-3040** or E-mail: amalloyindustries@gmail.com