


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA CAST Ni-E	 Welding Alloys
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CLASSIFICATION

ASME IIC SFA 5.15 / AWS A 5.15: ENi-CI
EN ISO 1071: E C Ni-CI 3

DESCRIPTION

- Basic-graphite coated electrode with a pure nickel core wire
- Joining and repairing all types of cast irons
- Cold welding of grey or malleable cast iron types
- Excellent wetting action even on difficult to weld or old cast irons
- Sound and easy machinable deposit

APPLICATIONS

Suitable for pumps, casings of machines, gearboxes, pulleys, piston grooves etc.

- Lamellar grey cast irons EN-GJL-100 to EN-GJL-350
- Malleable cast irons EN-GJMB-350-10 to 650-2
- Nodular cast irons EN-GJS-400-15 to EN-GJS-800-2

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Fe	Ni
1.2	0.8	0.1	1.6	Bal.

TYPICAL ALL-WELD MECHANICAL PROPERTIES

Rm [MPa]	Hardness [HB]
320	180

OPERATING CONDITIONS

Electrode ØxL [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Current [A]	65-75	95-105	140-150
= -	~ 50V		

Weld on clean, grease free, freshly ground surfaces

Use as low a heat input and interpass temperature as possible

Thin passes, weave width not more than twice the diameter of the core wire

Immediate peening of each bead to relieve welding stresses is recommended, particularly under conditions of heavy restraint.

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PD, PE
ASME IX: 1G, 1F, 2G, 2F, 3F, 3G, 4F, 4G

PACKAGING

Electrode ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Weight/box [kg]	5	5	5

Other packaging and other diameters: please contact us