

Cast Nic

AWS E NiCl
cast iron electrode
(machinable electrode)

DESCRIPTION

Cast Nic is a graphite coated pure Nickel Electrode giving highly machinable weldmetal. The weldmetal is highly resistance to corrosion. It is specially formulate for repair of broken castings, joining of cast iron to mild steel and unknown composition of meta. The electrode can easily operate on AC as well as DC(+) current.

CLASSIFICATION / CONFORMS TO

- ▶ AWS SFA A5.15 E NiCl
- ▶ AWS A5.15/A5.15M : R2006 E Ni-Cl

WELDING POSITION



TYPICAL WELDMETAL CHEMISTRY

As required by AWS SFA 5.15

Elements	C %	Mn %	Si %	S %	Fe %	Ni %	Cu %	Al %
AWS Requirement	2.0 Max	2.5 Max	4.0 Max	0.03 Max	8.0 Max	85.0 Max	2.5 Max	1.0 Max
Typical Values	1.0 Max	1.0 Max	0.50 - 1.0	0.03 Max	3.0 Max	94.0 Min	0.50 - 0.75	0.10 Max

RECOMMENDED WELDING CURRENT

Polarity	2.50 x 350 mm	3.15 x 350 mm	4.00 x 350 mm	5.00 x 350 mm
DC / AC (+)	45 - 60 (Amps.)	70 - 90 (Amps.)	90 - 105 (Amps.)	100 - 110 (Amps.)

DIAMETER / PACKING DETAILS

Diameter	Length	Weight of Packet	Weight of Box
2.50 mm	350 mm	2 Kg / 1 Kg	10.0 Kg
3.15 mm	350 mm	2 Kg / 1 Kg	10.0 Kg
4.00 mm	350 mm	2 Kg / 1 Kg	10.0 Kg
5.00 mm	350 mm	2 Kg / 1 Kg	10.0 Kg



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