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

F NiCl

► AWS A5.15/A5.15M : R2006 E Ni-CI

WELDING POSITION



APPLICATION

- Repair of broken casting joints, joining of cast iron to mild steel
- Joining of unknown composition metal
- ▶ Welding on machine base, frames cylinder blocks, correcting and foundry defects

KEY FEATURES

- Excellent weldmetal machinability deposit
- Used for welding of cast iron to stainless steel and mild steel
- Intended to join and repair
- No preheat is required during welding

TYPICAL WELDN	METAL CHEMISTRY As required by AWS SFA 5.19						WS 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 WE	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			



Manufactured by :

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