Key Facts

- Stable arc with clean ductile bead appearance
- Used on all types of cast iron
- Low amperage
- Refined grain structure

Description

A pure nickel electrode which is designed to operate at low currents which minimise heat input and thus facilitates the cold welding of cast iron. Weld induced stresses can be reduced by hammer peening.

Classification

AWS A5.15: E Ni-CI

Welding Positions

Flat, horizontal, and vertical-up.

Markings & Identification

End tip Colour: Green
End side Colour: Green
Printing: GEMINI Ni98

Applications

ENi-CI is a covered welding rod with pure nickel core and graphitic for cast iron. It is the best for repair cracked or worn castings and surfacing welding, as well as joining cast iron parts with dissimilar metals. The deposited metal is very good machinable and with a high toughness and excellent crack resistibility. The rod must be bake at a temperature 80°C-120°C for 1 hour before welding. In welding, lower current is recommended, meanwhile, hammering the welded seam to dispel stress around the welding region and to avoid crack. Suitable for all types of cast iron and also non-ferrous metals.

- Pumps and block repairs
- All maintenance workshops
- Cast iron grate repair



Typical All Weld Metal Analysis

C - Carbon	Mn - Manganese	Ni - Nickel
0.30%	0.20%	97.00%

Typical All Weld Metal Mechanical Properties

Vickers Hardness HV30:	160 HV

Packaging & Ordering Information

Size	Packet	Ctn	Current Range	Part Number
2.6mm	1kg	20kg	50-80	100092
3.2mm	1kg	20kg	80-110	100093
3.2mm	6stk	10pkt	80-110	100093H
4.0mm	1kg	20kg	1101-150	100094

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.