

Standards :

TS 9463 EN ISO 1071 :	E C Ni-CI 1
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AWS A5.15 :	E Ni-CI

**Chemical Composition of Weld Metal-
% (Typical) :**

C	Ni
0.50	min. 96

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (L ₀ =5d ₀)(%)	Hardness (HB)
200	250	3	-170

Typical Base Material Grades :

- * Non-conductive, basic-graphite-coated nickel stick electrode.
- * Repair welding of problematic cast iron parts of irregular shapes.
- * Joint welding of cast iron parts, and cast iron parts to steel parts.
- * Pre-heating to 200 °C is recommended for thick-walled components.
- * Welding in short runs, and peening are required.

Welding Positions :



Current Type :

D.C.(+)

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.50 x 300	3/32 x 12"	70 - 100	1950
3.20 x 300	1/8 x 12"	90 - 110	3050
4.00 x 400	5/32 x 16"	110 - 130	---

Approvals :

TSE, CE, GOST-R, SEPRO