

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	rest

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 :

- * Joint welding of grey cast iron, temper cast iron, nodular cast iron as well as joint welding of cast iron with steel, stainless steel and Monel metal.
- * Ni cored stick electrode.
- * Welding in short passes, and gently striking the bead of each pass with a hammer when the bead is hot are required.
- * Ni-cored stick electrode.

Welding Positions :



Current Type :

- D.C.(-)
- A.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"	60 - 90	1830
3.20 x 300	1/8 x 12"	90 - 110	2840
4.00 x 400	5/32 x 16"	110 - 130	5500

Approvals :

TSE, CE, GOST-R, SEPRO