

## Ni(-)

**CATEGORY** SMAW Stick Electrodes

**TYPE** Special coated electrode for welding cast iron with a pure nickel core wire.

**APPLICATIONS** Joining and cladding grey and malleable cast iron, also suitable for joint welds between steel , copper and copper alloys, especially for maintenance and repair.

**PROPERTIES** Excellent welding properties with easily controllable flow permits spatter free welding with very low current. Due to the very low heat input and unique composition of Ni(-) the transition zone will stay well machinable and is therefore well suited to use as first layer in case off multi-layer welding. The weld metal will show no undercut !  
Preheating is normally done to slow down the cooling speed, in case you can not control the cooling speed it is better to keep the work peace at a low temperature during welding and hammer immediately after welding.

**CLASSIFICATION**

AWS	A 5.15: E Ni-C1
EN ISO	1071: E C Ni-CI1
DIN	1736: E Ni-BG 22

**SUITABLE FOR** Grey cast iron, Malleable cast iron, EN 1561: EN-GJL-100 (GG10) till EN-GJL-350 (GG35), EN 1562: EN-GJMB-350 (GTS 35) till EN-GJMB-550 (GTS 55), EN- GJMW-350 (GTW 35) till EN- GJMW-550 (GTW 55).

**APPROVALS** CE approved

**WELDING POSITIONS:**



C	Mn	Si	Cr	Ni	Mo
				98	

### MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW		240-290					160

AW: as welded

### WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
2.5	350	60-80	3.5	21	19.4
3.2	350	80-110	3.5	21	32.8
4.0	350	110-140	3.5	21	48.7
5.0	450	140-170			98.1

**REDRYING TEMPERATURE** 200°C / 1hr