

Classification AWS A 5.15 E Ni-C1
 Din 8573 E Ni BG 11

Description and Applications MMA Electrode with graphite base coating. Pure nickel weld deposit for the weld repair of grey cast iron. Machineable deposit, which, when peened, provides a gas-tight joint

Base materials to be Welded Grey and flake cast irons. All cast irons to provide machineable deposit and gas tight joints.

All weld metal Mech. Properties

UTSn/mm	Yield 0.2%	Elong A5	HardnessHB
>300	~180		

Typical weld metal Composition %

C.	Si.	Mn.	Cr.	Ni.	Fe.
1.2	<2.0	<1.0		>95.0	<2.0

Packaging Data

Size mm	2.5	3.2	4.0	5.0
Elec/packet	251 156		100	66
Elec/carton	1004 624		400	264
Packs/carton	4 4		4	4
Kg/packet	5 5		5	6.5
Kg/carton	20 20		20	26

Amperage

Amperes =/+ 70	100	145	180
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Welding Instructions Ensure heat input minimal, remove all scaling, grease and loose debris. Deposit short stringer beads and peen to reduce stresses

Additional Information For further information see Westbrook sheet `Cast Iron Welding`