

Classifications

EN ISO 1071:2003	: E C Ni-CI 1	KS D 7008	: DFCNi
AWS A 5.15-90	: ENi-CI	JIS Z 3252	: DFCNi

Description

- Covering is graphite type for repairing and joining of various kinds of cast iron products such as cylinder covers, motor beds, casings and gears or repairing co cast iron, alloy cast iron and malleable cast iron.
- Easily machinable deposited weld metal.
- Chip off base metal completely at the repairing part.
- Preheat at 150-300°C. The temperature to be applied varies in accordance with kind, shape and size of base metal.
- Redry the electrode at 70-120°C for 30-60 minutes prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cu	Fe	Al
0.55	0.40	0.35	0.009	0.001	Rem.	0.05	0.85	0.05

Typical mechanical properties of all-weld metal

T.S (MPa)	HV	Hardness HB	HS
420	160~190	152~181	24~28

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	550
Amp. (A)	F	60~90	70~110	110~130	130~150

Approvals

CE