

ROCAST-NI

ELECTRODE DEPOSITING PURE NICKEL FOR
MACHINABLE WELDING OF CAST IRON

BASIC ALLOY: C, NI
AWS/SFA-5.15: E Ni CI
EN ISO 1071 E C NI-CI 3

KEY FEATURES:

A light coated electrode depositing pure Nickel in weld metal to work on cold conditions without pre-heating the jobs. The nickel content in weld metal deposit allows to achieving a soft and tough weld. The tensile strength is good enough to match parent metals tensile strength. Deposits are machinable.

APPLICATIONS

- Suitable to weld carbon steel to cast iron.
- Repairs on cast iron castings.
- Filling up casting defects.
- Building up worn out surfaces..
- Engine blocks, pump casing, impellers, Gears and valve bodies.

RE-DRY CONDITIONS:

- Re-Dry the electrode at 150°C for 1 hour.

WELDING NOTE:

1. clean the weld area free of any surface contaminations.
2. Bevel broken part or cracks to 70-80° Vee.
3. Use the short arc and as possible as low current.
4. preheat the part, if necessary.

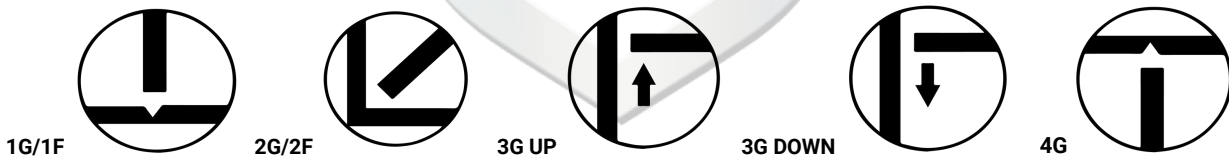
CHEMICAL COMPOSITION:

C	Mn	Si	Ni	Fe
1.20 Max	1.00 Max	1.00 max	96 Min	Balance

WELD METAL HARDNESS

140-160VHN

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+/ AC) Amps	Wt. of /pkt.	Wt. of Case
2.50/ 2.40	3/ 32"	60-80	2	20
3.15/ 3.20	1/ 8"	80-110	2	20
4.00	5/ 32"	110-130	2	20
5.00	3/ 16"	140-180	2	20