

OK Ni-CI



OK Ni-CI is a nickel cored electrode for joining normal grades of cast iron, such as grey-, ductile- and malleable irons. It is also suitable for rectification and repair of these grades and for joining them to steel. Deposition is done on cold or slightly preheated cast iron. Weld metal is well machinable. Typical applications are repair of cast iron parts such as cracks in engine blocks, pump housings, gear boxes, frames as well as foundry defects.

Classifications:	SFA/AWS A5.15:ENi-CI, EN ISO 1071:E C Ni-CI 3
Welding Current:	AC, DC+-
Alloy Type:	Ni-base alloy
Coating Type:	Basic Special high graphite

Typical Tensile Properties

Condition	Tensile Strength
AWS	
As welded	300 MPa

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Al	Cu	Fe
1.0	0.2	0.3	93.5	0.1	0.3	4.5

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 300 mm	55-110 A	21 V	0.71	83	46 s	0.9 kg/h
3.2 x 350 mm	80-140 A	20 V	0.68	45	66 s	1.2 kg/h
4.0 x 350 mm	100-190 A	19 V	0.70	29	71 s	1.7 kg/h