

HILO NI-CI

CLASSIFICATION			
AWS A 5.15:	ENi-CI	DIN 8573:	E Ni BG 13
ISO 1071:	E C Ni-CI 3		

DESCRIPTION AND APPLICATIONS			
<ul style="list-style-type: none">• Graphite-containing basic electrode with nickel core giving a machinable deposit for welding of cast iron• Particularly suited to welding from cold of old and new grey and malleable cast irons, even when impregnated with oil• Very soft fusion, good bead appearance free of undercut• Low hardness deposit and heat affected zone, easily machinable• Particularly suited to repairing holes and cracks• Peening recommended immediately after each pass for efficient elimination of internal contraction stresses			

Base materials

Grey cast iron to different steels:

ASTM	DIN	NFA
A48 Class 25B – A48 Class 60B	GG-15 to GG-40	FGL 150 to FGL 400

TYPICAL ALL-WELD METAL ANALYSIS [%]						
C	Si	Mn	Cu	Fe	Ni	
0.6	0.5	0.2	0.6	6.0		Rem.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES	
Rm [MPa]	Hardness
>300	approx. 170 HB

OPERATING CONDITIONS			
Electrode ØxL [mm]	2.5x350	3.2x350	4.0x350
Current [A]	80	110	140

Weld on clean and exempt from grease surfaces (previous grinding of the joint). Apply a heat input as low as possible and keep the temperature low (< 70°C). Weld with lowest practical current and depose short and narrow beads to reduce the risk of producing cracks in the base metal.

To reduce stresses, produced during welding, hammering of the beads is recommended after the deposition of short runs (essential on rigid pieces).

=+ ~40V

WELDING POSITIONS			
1G/PA, 2F/PB, 2G/PC, 3G/PF, 4G/PE			

PACKAGING			
Electrode ØxL [mm]	2.5x350	3.2x350	4.0x350
Weight/box [kg]	5	5	5
Piece/box	~245	~147	~98

Other packaging and diameters: please consult us