

### Brand Name & Classification

AWS/ASME SFA-5.15 E Ni CI  
DIN 8573: E Ni BG-22

### Properties

Electrode with pure Nickel core wire, suited for cold welding of cast iron and for joining cast iron parts to steel, copper and nickel.

### Application

Grey cast iron  
White & black heart malleable cast iron  
Nodular cast iron

### Weld Metal Analysis Typical values

Carbon: 0.50

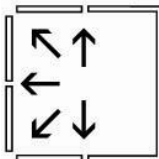
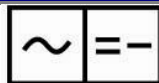
Iron: 2.00

Nickel: Balance

### Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>200 N/MM2	380 - 420 N/mm2	> 5 %	Hardness HB 140

### Welding Current & Positions



### Current

Dia	Length	Amperes
2.6	300	60-80
3.2	350	80-120
4.0	350	110-150