

### Brand Name & Classification

AWS/ASME SFA-5.15: E NiCu-B  
DIN 8573: E NiCu BG-22

### Properties

Electrode having a Nickel copper core wire, suited for welding of cast iron with or without preheat. Preferably used for cover and filler passes with dilution kept low. Weld metal closely matches colour of base metal.

### Application

Nodular cast iron  
White & black heart malleable cast iron  
Cast iron with lamellar graphite

### Weld Metal Analysis Typical values

Carbon: 0.50

Iron: 4.00

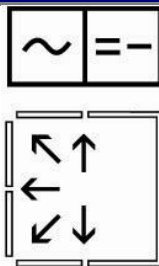
Nickel: Balance

Copper: 30.00

### Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>200 N/MM2	380 - 420 N/mm2	> 15 %	Hardness HB 150

### Welding Current & Positions



### Current

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