

Superfonte Ni Ci

Brand Name & Classification

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

Approvals Grade

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

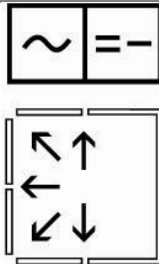
Iron:2.00

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