



HILCO NICKEL IRON

Stick electrodes – repair & maintenance – cast iron

EN ISO 1071: E C Ni Fe-1 1

AWS A5.15: E Ni Fe-CI

Coating type:
Basic

Current:



Welding positions:



Nickel Iron is our basic coated electrode for repair, construction and production welding all cast commercial iron grades including grey, malleable, nodular and phosphorous (P > 0,02%) cast iron. The electrode deposits a high-grade nickel-iron weld metal: ideal for highly restrained or thick walled work pieces including applications where toughness and crack resistance is important. Both weld metal and transition zone are easily machine able using cutting tools.

Base materials to be welded:

- Lamellar grey cast irons GG10 to GG40
- Malleable cast irons GTS35-GTS 65, GTW35-GTW65
- Nodular cast irons GGG40-GGG70
- Joining and repairing
- Dissimilar joining cast iron to steel

Applications:

- Repair & Maintenance

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	Ni	Fe
1,1	0,95	1,2	54	42

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Hardness
As welded	350	500	12	Approx. 170 HB

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	300	15,9	60-80
3,2	350	31,3	70-100
4,0	350	47,4	95-130