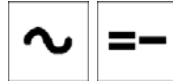


Coating type:

Basic

Arc voltage: 60V

Current:



Tip colour:

-

Welding positions:



Printing:

HILCO PURE NICKEL / E Ni CI

Pure Nickel is our basic coated electrode for cold welding grey and malleable cast iron grades and for joining these base metals to steel, copper and copper alloys. The electrode deposits a high-grade pure nickel weld metal: ideal for repair welding cracked and worn castings including highly contaminated cast materials. Both weld metal and HAZ are soft and easily machine able using files. Pure Nickel is ideally suited for the combined welding with Nickel Iron (E NiFe CI), buttering with Pure Nickel and filling with Nickel Iron.

Base materials to be welded:

- Lamellar grey cast irons GG10 to GG40
- Malleable cast irons GTS35-GTS 60, GTW35-GTW60
- Joining and repairing
- Dissimilar joining cast iron to steel, copper, copper alloys

Applications:

- Repair & Maintenance

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	-	-	-	-	-

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	Fe	Al
≤ 2,00	≤ 2,50	≤ 4,0	≤ 0,030			≤ 85,00		≤ 2,5		≤ 8,00	≤ 1,0

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Hardness
As welded	≥ 220	-	-	175 HB

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	300	20,4	40- 70
3,2	350	32,2	70-100
4,0	350	47,4	90-140