



Selectarc Fonte NiCu

*Nickel Copper
Cast Iron Electrode*

Classification

AWS A 5.15 : ENiCu-B
ISO 1071 : E C NiCu 3

DIN 8573 : E NiCu BG 12

Description & Applications

Graphite-basic coating electrode for cold welding and repairing of grey and malleable cast iron. Due to a nearly colour matching deposit and its good welding properties this electrode is suited especially for repairing casting defects.

Base materials

Grey cast iron, malleable and nodular cast iron :

ASTM	DIN	NFA
A48 class 25B to 60B	GG-15 to GG-40	FGL 150 to FGL 400
A536 Grade 60	GGG-40 to GGG-50	FGS 400-12

Typical Weld Metal Composition (%)

C	Si	Mn	Fe	Cu	Ni
0.8	0.9	2.0	4.0	30.0	Rem.

All Weld Metal Mechanical Properties

R _m (MPa)	Hardness
>450	approx. 160 HB

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	80	110	140

Weld on clean and exempt from grease surfaces (previous grinding of the joint). Reduce the heat input to a minimum, weld with the lowest practical amperage, keep temperature low (< 100°C) in order to reduce the risk of cracks in the base metal, depose short beads of about 6 cm and peen immediately. Reignite on the weld metal –not on the casting.

ind.12



= - ~ 50 V

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