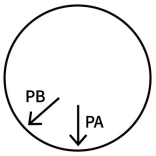
S-NCI

Classification

AWS A5.15/ASME SFA-5.15 ENi-CI
JIS Z 3252 DFCNi
EN ISO 1071 E C Ni-CI 1
KS D7008 DGCNi

Welding Positions





Features

- Graphite coated electrode
- Preheat at 150°C (302°F)

Polarity

AC or DC ±

Application Areas

- Repairing and joining of cast iron

Redrying Conditions

350°C (662°F) X 1hr

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Ni	Fe
1.38	0.79	0.30	0.004	0.003	98.3	0.58

Typical Mechanical Properties of All-Weld Metal

Hardness(HRB)
77.6

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	Packaging
2.6 (3/32)	300 (12)	55~80	PVC - Packet 2.5kg(5.5lbs), Carton 10kg (22lbs)
3.2 (1/8)	350 (14)	80~130	
4.0 (5/32)	350 (14)	110~160	