OK Ni-CI

OK Ni-CI is a nickel cored electrode for joining normal grades of cast iron, such as grey-, ductile- and malleable irons. It is also suitable for rectification and repair of these grades and for joining them to steel. Deposition is done on cold or slightly preheated cast iron. Weld metal is well machinable. Typical applications are repair of cast iron parts such as cracks in engine blocks, pump housings, gear boxes, frames as well as foundry defects.

Classifications	SFA/AWS A5.15 : ENi-CI EN ISO 1071 : E C Ni-CI 3

Welding Current	AC, DC+-
Alloy Type	Ni-base alloy
Coating Type	Basic Special high graphite

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Al	Cu	Fe
1.0	0.2	0.3	93.5	0.1	0.3	4.5

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Burn-off Time/ Electrode	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 300.0 mm (0.098 x 11,8 in.)	55-110 A	21 V	83	46 sec	71 %	0.9 kg/h (2,0 lb/h)
3.2 x 350.0 mm (1/8 x 13,8 in.)	80-140 A	20 V	45	66 sec	68 %	1.2 kg/h (2,6 lb/h)
4.0 x 350.0 mm (5/32 x 13,8 in.)	100-190 A	19 V	29	71 sec	70 %	1.7 kg/h (3,7 lb/h)

412031-en_US-FactSheet_Main-01 2021-04-05