



SUPERCAST Ni



- ▶ Pure Nickel Core Wire/Basic, Graphite Coating
- ▶ Soft Machineable Nickel Deposit for the Lower Strength Welding of Cast Irons

Identification

Coating - Black

End Tip - Plain

Classifications

AWS A5.15 ENi-CI

Description & Applications

SUPERCAST Ni is a basic, graphite coated AC/DC electrode for the lower strength welding of cast irons. It is characterised by a soft, smooth arc with low penetration and spatter levels on both AC and DC power sources. Ease of striking is a feature of Supercast Ni and it also has a particularly good wetting action resulting in well bonded welds of regular contour and attractive appearance.

This electrode is made from a pure nickel core wire and produces a ductile, fully machineable weld deposit. Supercast Ni may be used for the repair and reclamation of all standard grades of grey cast iron, malleable iron, austenitic cast iron and some grades of meehanite cast iron.

Operational Data

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE* (amps)	ARC VOLTAGE RANGE (volts)**
3.2	350	50 - 100	23
4.0	350	80 - 130	26

*Recommended for DC+ or AC (minimum 45 0CV) operation

** Voltage is determined by arc current and electrode arc length. Arc voltage shown are typical and are only to be used as a guide.

Typical All Weld Metal Chemical Analysis

Mn	Ni	S	Fe
0.3	97.0	0.006	Bal

Typical All Weld Metal Mechanical Properties

Yield Stress	220 Mpa
Tensile Strength	400 Mpa
Deposit Hardness	150 - 170 HV (30)

Packaging Data

ELECTRODE SIZE (mm)	PACKAGING (KG)			APPROX NO OF RODS PER KG	PART NUMBER
	Packet	Carton	Mini Pack		
2.5	2.5	15	0.5	37	SNI32
2.5	2.5	15	-	24	SNI40

Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.*

*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.