

UN-Ni55 Cast Iron Electrodes 铸铁焊条

Standard: AWS ENiFe-Cl JIS DFC Ni Fe GB/T Z408

Description: Repair welding of important gray iron casting and nodular iron casting, also for welding mild steel to all grades of cast iron.

Chemical composition of weld metal(%):

c	Mn	Si	S	Ni	Fe	Others
≤2.00	≤1.80	≤2.50	≤0.03	45-60	Remainder	≤1.00

Recommended current:

Weld rod diameter (mm)	2.5	3.2	4.0	5.0
Welding current (A)	50-80	80-100	110-140	150-180

PACKING

Size(mm)	2.5 × 300	3.2 × 350	4.0 × 350
Piece(1kgs)≈	50pcs	33pcs	20pcs

Pvc Box	1kgs	1kgs
Carton	10kgs	20kgs

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Model Name	Standard	Chemical composition	Description
UN-Ni 0	AWS ECI JIS DFC CI GB/T Z208	C 2.00-4.00 Si 2.5-6.5 Mn ≤ 0.75 Fe balance	Repair welding of defects of gray cast iron.
UN-Ni 100	AWS ENi-CL JIS DFC Ni GB/T Z308	C ≤ 2.00 Si ≤ 2.5 Mn ≤ 1.00 Ni ≥ 90 Fe ≤ 8	Repair welding of various kinds of cast iron products. Deposits nearly pure nickel which is easy machinable.
UN-NiCu	AWS ENiCu-B JIS DFC Ni Cu GB/T Z508	C ≤ 1.00 Si ≤ 0.8 Mn ≤ 2.50 Ni 60-70 Fe ≤ 6 Cu 24-35	Repair welding of gray iron casting strength of which is not so highly required.