

AP-Ni55 Cast Iron Electrode

Standard: AWS ENiFe-CI 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)	2.5x300	3.2x350	4.0x350
Piece (1kgs) ~	50pcs	33pcs	20pcs

Pvc Box	1kgs	1kgs
Carton	10kgs	20kgs

Cast Iron Electrodes

Model Name	Standard	Chemical composition	Description
AP-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.
AP-Ni 55	AWS ENiFe-CI JIS DFC Ni Fe GB/T Z408	C ≤2.00 Si ≤2.5 Mn ≤1.80 Ni 45-60 Fe balance	Repair welding of important gray iron casting and nodular iron casting, also for welding mild steel to all grades of cast iron.
AP-Ni 100	AWS ENi-CI 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.
AP-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.

