

SMAW Electrodes – Cast Iron

GC100

AWS A5.15 ENi-CI
ISO 1071-ECNi-CI N
JIS Z 3252 ECNi-CI N

Product Features:

- Graphite type nickel base covered electrode for cast iron welding repair.
- High welding performance and good arc stability in low current range.
- Lower hardness of weld metal to get good machinability, good toughness and crack resistance.

Applications:

- Suitable for build up and repair welding of various kinds of cast irons.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Fe
0.76	0.77	0.17	Bal.	3.2

Typical mechanical properties of all-weld metal

Tensile Strength N/mm ²	Hardness HV
412	199

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.6/300	3.2/350	4.0/350
Flat position	60~90	90~130	110~160

Note:

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