

SMAW Electrodes – Cast Iron

GCI-1

AWS A5.15 ENi-CI
ISO 1071-ECNi-CI 1
JIS Z 3252 ECNi-CI N

Product Features:

- Graphite type covered electrodes for cast iron welding and repair.
- High welding performance and good arc stability in low current range.
- Better machinability property than similar level electrodes.

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
0.38	0.26	0.14	Bal.	0.82

Typical mechanical properties of all-weld metal

Hardness HV
203

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

Diameter / Length	2.6/300	3.2/350	4.0/350
Flat position	60-90	70~120	110~150

Note:

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