

SMAW Electrodes – Cast Iron

GCI-2

AWS A5.15 ENiFe-CI
ISO 1071-ECNiFe-CI 1
JIS Z 3252 ECNiFe-CI N

Product Features:

- Graphite type covered electrodes for cast iron welding and repair.
- High welding performance and good crack resistance.
- All deposited metal contains approximately 55% Ni, 45%Fe.

Applications:

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

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

C	Si	Mn	Ni
1.12	1.52	0.55	54

Typical mechanical properties of all-weld metal

Hardness HV
209

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

Diameter / Length	2.6/300	3.2/350	4.0/350
Flat position	65-85	70~120	100~150

Note:

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