

GRICAST N

IDENTIFICATION

Gricast N, ENiCl

CLASSIFICATION

AWS/SFA5.15: ENiCl, IS: 5511-1991: ENi

DESCRIPTION

An extruded & graphite type coated electrode depositing pure Nickel weld metal for cold welding of cast Iron. Weld able in all positions. Arc striking and re-striking properties are excellent. Arc is soft & stable. The weld metal including the heat effected zone is easily machinable.

WELD METAL ANALYSIS (RANGE) %

C	Ni	Mn	Si	Cu	Fe	S	P	Al
2.0 max	85.0 max	2.5 max	4.0 max	2.5 max	8.0 max	0.03 max	0.03 max	1.0 max

MECHANICAL PROPERTIES (RANGE)

TS (N/mm2)	YS (N/mm2)	EL (%) (L=4D)	Impact Value	
300 - 400	-	-	Temp	Joules
			27°C	50

TYPICAL APPLICATIONS

Joining and surfacing of all types of Cast Iron, without pre-heating of the parent metal Repairing of mechanite, alloy & malleable cast iron.

WELDING INSTRUCTIONS

- Chip off the base completely at the repairing part.
- If there is a possibility that cracking spreads, make the stop holes at both the ends of repairing part.
- Keep the weld metal length less than 50mm to disperse welding heat. Adopt back stepping stone or symmetry method by turns.
- Hot peen in every pass.
- The preheat temperature vary in accordance with size, kind & shape of base metal. 150°C (320°F) appropriate in general

WELDING POSITION :

1G 2F

PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS AC / DC (+)	Packing / Box (kg)
2.5	350	50 - 80	2 x 5 = 10
3.15 / 3.20	350	80 - 130	2 x 5 = 10

4	350	110 - 160	2 x 5 = 10
5	350	120 - 180	2 x 5 = 10