

## Ratna Cast Ni

### CLASSIFICATION

- AWS/SFA-5.15 E NI CL
- DIN E NIG3

### APPLICATIONS

- Suitable to weld carbon steel to cast iron.
- Repairs on cast iron castings.
- Filling up casting defects.
- Building up worn out surfaces.
- Engine blocks, pump casing, impellers, gears and valve bodies.

### DESCRIPTION

- A light coated electrode depositing pure nickel in weld metal to work on cold conditions without pre-heating the jobs. The nickel content in weld metal deposit allows to achieving a soft and tough weld. The tensile strength is good enough to match parent metals tensile strength. Deposits are machinable.

TYPICAL WELD METAL CHEMICAL PROPERTIES (ELEMENT %)				
CARBON (C)	MAGNESIUM (MN)	SILICON (SI)	NICKEL (NI)	IRON (FE)
1.20 MAX	1.00 MAX	1.00 MAX	96.0 MIN	BALANCE

CURRENT POLARITY	WELDING POSITION
DC(+), AC	FLAT, HORIZONTAL FLAT

TYPICAL WELD METAL MECHANICAL PROPERTIES (ELEMENT %)
HARDNESS VPN
140-160 VPN

SIZE AND CURRENT RECOMMENDATIONS		
SIZE D X L (MM)	SIZE D X L (IN)	CURRENT (AMPS) DC+, AC
2.5mm x 350mm	3/32" x 14"	60-80
3.2mm x 350mm	1/8" x 14"	80-110
4.0mm x 350mm	5/32" x 14"	110-140

### RE-DRY CONDITIONS

- Re-dry the electrode at 150°C for 1 hour.

NOTE:  
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