



Selectarc Fonte NiCu

*Nickel Copper
Cast Iron Electrode*

Classification

AWS A 5.15 : ENiCu-B
ISO 1071 : E C NiCu 3

DIN 8573 : E NiCu BG 12

Description & Applications

Graphite-basic coating electrode for cold welding and repairing of grey and malleable cast iron. Due to a nearly colour matching deposit and good welding properties, this electrode is especially suited for repairing casting defects.

Base materials

Grey cast iron, malleable and nodular cast iron :

ASTM	DIN	NFA
A48 class 25B to 60B	GG-15 to GG-40	FGL 150 to FGL 400
A536 Grade 60	GGG-40 to GGG-50	FGS 400-12

Typical Weld Metal Composition (%)

C	Si	Mn	Fe	Cu	Ni
0.8	0.9	2.0	4.0	30.0	Rem.

All Weld Metal Mechanical Properties

R _m (MPa)	Hardness
>450	approx. 160 HB

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	60 - 80	80 - 100	100 - 130

Weld on clean and exempt from grease surfaces (previous grinding of the joint). Reduce the heat input to a minimum, weld with the lowest practical amperage, keep temperature low (< 100°C) in order to reduce the risk of cracks in the base metal, depose short beads of about 2.5 to 4.0 cm and peen immediately. Reignite on the weld metal, not on the casting.



= + ~ 50 V

FT En-058-190211



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