



**Cast iron welding electrodes**

A nickel-cored electrode designed to weld average grades cast irons. The weld metal is soft and easily machinable; deposition is performed on cold or slightly preheated material. It is suitable for joining cast irons to rectify casting and repair broken parts.

3.2mm

Lot No.: AD4093706

Date: Jul.05.2024

AK ENi-CI	EN ISO 1071	AWS A5.15	Certificate number
Welding electrodes	E C Ni-CI 3	ENi-CI	2407-0501

**CHEMICAL COMPOSITION OF WIRE (%)**

	C	Si	Mn	S	Fe	Ni	Al	Cu	—	—
%	1.16	1.28	0.65	0.010	R	91.44	0.11	0.12	—	—

**THE TEST RESULTS OF MECHANICAL PROPERTY OF DEPOSITED METAL**

Tension Test			Impact test	
Tensile Strength (Mpa)	Yield Point (Mpa)	Elongation (%)	Temp (0C)	Impact Value(J)
400	300	4.5	—	—

Bend test—Face	Bend test—Side	Redrying	X Reys Test	Dictionary flux	HRC	HD
—	—	—	—	—	180	—

2.0mm (5/64" )	2.5mm(3/32" )	3.2mm(1/8" )	4.0mm(5/32" )	5.0mm(3/16" )
—	350mm	350mm	350mm	—

**NOTICE:** The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.

**CAUTION:** Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJune Road, Miami, FL 33126: OSHA Safety and Health Standards 29 CRF 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.