PRODUCT DATA SHEET

CAST IRON ELECTRODES

WCD 6128

Supercast Ni

SUMMARY

- Pure Nickel Core Wire/Basic, Graphite Coating
- Soft Machineable Nickel Deposit for the Lower Strength Welding of Cast Irons

IDENTIFICATION

Coating - Black **Tip** - Plain **Imprint** - WIA SC Ni

CLASSIFICATION

- AWS A5.15: ENi-CI

DESCRIPTION AND APPLICATION

Supercast Ni is a basic, graphite coated AC/DC electrode for the lower strength welding of cast irons. It is characterised by a soft, smooth arc with low penetration and spatter levels on both AC and DC power sources. Ease of striking is a feature of Supercast Ni and it also has a particularly good wetting action resulting in well bonded welds of regular contour and attractive appearance.

This electrode is made from a pure nickel core wire and produces a ductile, fully machineable weld deposit. Supercast Ni may be used for the repair and reclamation of all standard grades of grey cast iron, malleable iron, austenitic cast iron and some grades of mechanite cast iron.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELDING CURRENT RANGE *(A)	ARC VOLTAGE RANGE **(V)
3.2	350	50 - 100	23

*Recommended for DC +/- or AC (minimum 45 OCV) operation.
**Voltage is determined by arc current and electrode arc length.
Arc voltage shown is typical and is only to be used as a guide.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Si	Mn	S	Ni
1.0	0.4	0.3	0.006	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	300 MPa
Tensile Strength	400 MPa
Deposit Hardness	150 - 170 HV (30)

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		APPROX. NO. OF RODS PER KG	PART NO.
	PACKET	CARTON		
3.2	2.5	12.5	33	SNI32

Issue CA - December 2014