



COATED ELECTRODE FOR CAST IRON

ESSEN CAST 99

Classificações: **AWS A5.15:1990 ENi-CI ASME SFA5.15 ENi-CI**

ENi-CI- Nickel-iron electrode for welding cast iron

Special electrode designed for repair welding on cold gray cast iron pieces, producing a soft and easily machinable deposit, ideal for filling tight surfaces. It is recommended for joining cast iron with other materials, such as steels, cast steels, copper, among others, offering excellent resistance in the deposited material. In addition, it is suitable for hard-to-weld parts and for filling casting defects and grooves. It has good weldability in all positions, and the deposited material and transition zone can be easily filed, maintaining good ductility. This electrode is intended for restoration and filling, providing a high deposition rate with moderate penetration, optimized deposition advantage, and absence of porosity. Its mechanical machining is easy, ensuring excellent tensile strength and good elongation in the transition zone.

ALLOY TYPE:

C	Mn	Si	Fe	Ni	Cu	Al	S
2,00% Máx.	2,50% Máx.	4,00% Máx.	8,00% Máx.	85,00% Min.	2,50% Máx.	1,00% Máx.	0,030% Máx.

MECHANICAL PROPERTIES:

TENSILE STRENGTH:	YIELD STRENGTH:	ELONGATION:	IMPACT RESISTANCE:
276 a 448 MPa	262 a 414 MPa	3 a 6 %	135 a 218 HB

WELDING CURRENT:

CC- ; CA



Flat



Horizontal



Vertical



Overhead

PRODUCT CHARACTERISTICS:

DIAMETER (mm):	LENGTH (mm):	AMPERAGE (A):	PACKAGING (kg):
2,50	350	60 a 100	5,00
3,25	350	90 a 130	5,00
4,00	350	140 a 180	5,00

CUSTOMER SERVICE POLICY

The above information is for reference purposes only, it should not be considered as a guarantee or certificate. Many variables can influence the results of a welding operation. Uniweld Industria de Eletrodos LTDA is not responsible for any incorrect application of the product, We recommend that, if you have any questions, you contact our Technical Assistance department to get adequate support.