

Product Data Sheet

**Graphited, pure
nickel core wire.**

SUPER CAST ULTIMA

Classification AWS A 5.15 : ENI-CI

**Description and
applications**

Nickel electrode for welding of grey cast iron, malleable iron, cast iron and for welding on fatigued casted parts. For rectification of castings. Ferrocast ultima gives perfect welding results even with low amperages. The arc is smooth and intensive, low spatters, easy removal of slag. The weld is soft machinable, also the fusion zone.

**Typical weld
metal Chemical
Composition (%)**

C	Si	Mn	Ni	Fe
1.00	0.50	0.35	97.50	Rem.

**All weld metal
mechanical
properties
(typical)**

Tensile Strength R_m (N/mm ²)	Hardness
450	165 HB approx.

Amperes (A)

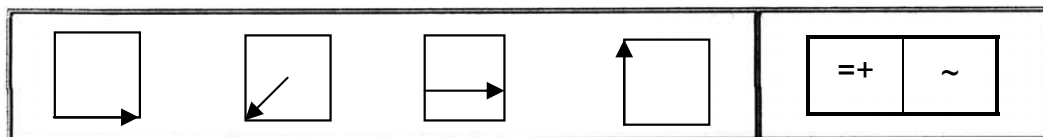
2.40mm	2.50mm	3.15mm	3.20mm	3.25mm	4.00mm
50-70	50-70	70-90	70-90	80-100	100-130

Welding instruction

Re-drying: 200-250°C /1h

Clean welding area carefully and remove cast skin from base material. Low heat input during welding is required. Weld bead width not more twice of electrode diameter, length max. 10 times. For reducing the tension the weld should be hammered just after welding.

Welding positions



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