

# ES Ni-CI

Type Basic special

SMAW

ENi-CI

**ESWECO**  
*The Art of Welding*

## Description

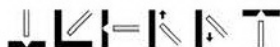
A nickel-cored electrode for welding normal grades of cast iron. The weld metal is soft and easily machinable. Deposition is performed on cold or slightly preheated material.

The electrode is suitable for joining cast iron for the rectification of casting and the repair of broken parts.

ES Ni-CI is specifically suited for repairing cracked or porous castings and to weld cast iron to itself or dissimilar metals such as low alloy and carbon steels.

## Current

AC, DC+ OCV 50 V



## Classifications

SFA/AWS A5.15 ENi-CI  
EN ISO 1071 E C Ni-CI 3

## Typical all weld metal composition, %

C	Si	Mn	Ni	Fe
0.9	0.7	0.6	>92.0	3.5

## Typical mech. Properties all weld metal

Tensile strength, MPa 300  
Hardness: 150 HB

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	300	55-110	20
3.2	350	80-140	20
4.0	350	100-190	20