

PRODUCT INFORMATION

STAVINOX Ni-CI

AWS A:5.4: ENi-CI

DESCRIPTION

STAVINOX Ni-CI is a pure nickel cast iron welding electrode that offers exceptional machinability. It produces a smooth and concentrated arc, making it easy to remove slag during the welding process, and is well suited to repair and joining of grey cast iron components.

WELDING POSITIONS



Suitable for AC and DC+ welding, delivering a stable, concentrated arc for controlled deposition on cast iron.

TYPICAL WELD METAL COMPOSITION

C	2.00 Max	Ni	85.0 Min
Si	4.00 Max	Al	1.0 Max
Mn	2.50 Max	Cu	2.5 Max
S	0.03 Max		
Fe	8.0 Max		

TYPICAL MECHANICAL PROPERTIES

Yield Strength Ult	>400 N/mm ²
Tensile Strength	278-448 N/mm ²
Elongation	3-6
Hardness	135-218

MATERIAL TO BE WELDED

STAVINOX Ni-CI is recommended for the repair, joining and build-up of grey cast iron (GCI) components where good machinability of the finished weld is required, including castings with shrinkage cavities, porosity, or worn surfaces.

AVAILABLE FORMATS

RE5003220-SV	3.2mm 2kg VP
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For further information, contact Weldability-SIF on +44 1462 482200 or email orders@weldability-sif.com



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