

## PRODUCT INFORMATION

### SIFTRODE CAST NI

EN ISO 1071-A E C Ni-CI  
AWS A5.15 E Ni-CI  
DIN 8573 E Ni BG1

## DESCRIPTION

Cast iron electrode with Ni pure core wire. Dedicated for cold welding grey and malleable cast iron and joining cast iron with steel. Welding is possible in all positions including vertical down.

## WELDING POSITIONS



Welding Current: AC, DC+  
Suitable positions: PA, PB, PC, PE, PF, PG

## TYPICAL WELD METAL COMPOSITION

Ni	96.0 %
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## TYPICAL MECHANICAL PROPERTIES

Ult Tensile Strength	≥ 300 N/mm2
Hardness	160 [HB]
Redrying	200° / 1h

## MATERIAL TO BE WELDED

Grey cast iron, malleable cast iron

## AVAILABLE FORMATS

ELECTRODE RODS (MMA / SMAW)			
Dia	1.0kg Pkt		Approx Pcs/KG
2.5mm	RE5002501		
3.2mm	RE5003201		
4.0mm	RE5004001		

CURRENT RANGE	
Dia (mm)	Amps
2.5	60-80
3.2	80-110
4.0	110-150

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email [service@wholeweld.co.uk](mailto:service@wholeweld.co.uk)

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