

## 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 <sup>2</sup>    |
| Tensile Strength   | 278-448 N/mm <sup>2</sup> |
| 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 |
|--------------|--------------|

For further information, contact Weldability-SIF on +44 1462 482200 or email [orders@weldability-sif.com](mailto:orders@weldability-sif.com)



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