

RepTec Cast1

Key Features

- Nickel base electrode for repair welding
- Preferable welding on DC-, gives pulsed arc welding, deep penetration, smooth surface, no lack of fusion
- Welding on AC, lowest heat input, important at filling
- Best choice for multilayer welding
- Produces a soft malleable weld deposit

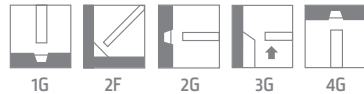
Typical Applications

- Ni-electrode for repair welding of lamellar cast iron, malleable cast iron and cast iron to steel.
- Can be used for joining these cast irons to carbon steels and Monel where higher strength is not required.
- Reduced hardenability due to dilution makes it useful for buttering runs before filling with more economical NiFe types.

Conformances

AWS A5.15: ENi-CI

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	579031-1	Linc Pack 1.0kg
3.2	350	579048-1	Linc Pack 1.0kg

Mechanical Properties

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Hardness HB10
Requirements - AWS	262-414	276-448	3-6	135-218
Typical Results - As Welded	270	445	8	175

Deposit Composition

	%C	%Fe	%Ni
All Weld Deposit	0.7	2.0	97

Typical Operation Procedures

Polarity	Current (amps)	
	2.5mm	3.2mm
AC/DC-	50-100	70-130