GRICAST 6

TOP FEATURES

- Basic graphite coated electrode with nickel copper core for welding and repair welding lamellar and spheroidal cast iron
- Suitable for filler and top layers (for buffer layers, use REPTEC CAST 1)
- Short-bead-welding is recommended

CLASSIFICATION

AWS A5.15	E NICU-B
EN ISO 1071	EC NI-CU-B 1

CURRENT TYPE

AC/DC+

TYPICAL APPLICATIONS

- Filling up of casting defects

WELDING POSITIONS

All position, except vertical down

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Ni	Cu	Fe
0.5	1.0	0.07	bal.	30	3.5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Hardness (HB10)
Required: AWS A5.5	AW	not specified	not specified	not specified	not specified
EN ISO 1071	AW	190	300	15	not specified
Typical values	AW	250	450	15	150

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	70-120
4.0 x 400	100-140

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	CBOX	155	5.2	99893235-2
4.0 x 400	CBOX	102	5.9	99894040-2

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.