



TECHNICAL INFORMATION SHEET

HARRIS 65 NICKEL ELECTRODE

PRODUCT INFORMATION:

Premium cast-iron electrode (AC-DC). For gray and alloyed cast iron. 65. Nickel is for the repair of all types of cast iron. It yields dense, strong, yet very machinable deposits. It is ideal for the repair of "Meehanite", "Ni-Resist", and ductile iron Welding cast iron to steel. Typical applications embody the repair of castings, housings, gear teeth, motor, machine bases, etc.

TYPICAL AS WELDED MECHANICAL PROPERTIES:

Tensile Strength: 74,000 PSI
Yield Strength: 54,000 PSI
Elongation 22%
Hardness Rockwell B 88-90, Brinell 180, Vickers 189

GENERAL WELDING PROCEDURE:

- Use AC or DC reverse polarity with a short arc. Prepare the weld joint by cleaning and beveling as required
- Use Harris Chamfer Arc for grooving, and tack weld cracks,
- Generally, preheating is not needed on thin cast iron.
- Preheat 400F - 500F for heavy sections of cast iron
- Lightly peen between passes
- Allow casting to cool slowly

SUGGESTED WELD SETTINGS:

3/32	1/8	5/32	3/16
50 – 80 AMPS	70 –110 AMPS	100 – 140 AMPS	130-175 AMPS

SPECIFICATION COMPLIANCE:

Harris Internal Engineering Standards.

SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.

ARC RAYS can injure eyes and burn skin.

FUMES AND GASES can be hazardous to your health.

HEAT RAYS, (infrared radiation) from flame or hot metal can injure eyes.

ELECTRIC SHOCK can kill.

- Before use, read and understand the manufacturer's instructions, Safety Data Sheets (SDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

WARNING: This product contains or produces a chemical known to the State of California to cause cancer and birth defects, (or other reproductive harm).

STATEMENT OF LIABILITY- DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

THE HARRIS PRODUCTS GROUP

A LINCOLN ELECTRIC COMPANY 

4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015
Additional information is available at our web site: www.harrisproductsgroup.com