



TECHNICAL INFORMATION SHEET

HARRIS 65 NICKEL ELECTRODE

PRODUCT INFORMATION:

Premium nickel-iron alloy 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: Up to 120,000 PSI
Yield Strength: Up to 85,000 PSI
Elongation: 22% minimum

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, tack weld cracks,
- Generally, preheating is not necessary on thin sections; Preheat of 400F - 500F is a good recommendation for welding heavier castings
- Stringer beads provide the best performance; however, a slight weave also provides good welds.
- Skip or back-step weld. Short deposits no longer than 1 1/2" provide the best outcome.
- Peen each bead while still hot to stress relieve. Allow casting to cool slowly

SUGGESTED WELD SETTINGS:

3/32	1/8	5/32
30 – 70 AMPS	50 – 100 AMPS	75 – 125 AMPS

SPECIFICATION COMPLIANCE:

Produced to Harris Products Group engineering standards..

SAFETY INFORMATION:

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

ARC RAYS can injure eyes and bum 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 causes 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.

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Additional information is available at our web site: www.harrisproductsgroup.com