

# REPTEC CAST 1 (Gricast 1)

## TOP FEATURES

- Ni-electrode for repair welding of lamellar cast iron, malleable cast iron and cast iron to steel
- Produces a soft malleable weld deposit
- Hardness weld deposit ~ 175 HB
- 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

## TYPICAL APPLICATIONS

- Machine bases, pump bodies, engine blocks, gears and transmission housings.

## CLASSIFICATION

AWS A5.15	ENi-CI
EN ISO 1071-A	E C Ni-CI 1

## CURRENT TYPE

DC+/AC

## WELDING POSITIONS

All position, except vertical down

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

	C	Fe	Ni
Min.	not specified	not specified	85
Max.	0.20	8.0	not specified
Typical	0.7	2.0	97

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Hardness (HB10)
Required: AWS A5.5	AW	262-414	276-448	3-6	135-218
EN ISO 1071	AW	200	250	3	not specified
Typical values	AW	270	445	8	175

\* AW = As welded

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	50-100
3.2 x 350	70-130
4.0 x 400	90-150

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	CBOX	245	4.2	400885-2
3.2 x 350	CBOX	162	5.1	400892-2
4.0 x 400	CBOX	112	6.4	400908-2

### 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.  
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