

RepTec Cast 31

Key Features

- Nickel / Iron electrode for repair welding
- Preferred welding polarity is DC-
- Weld deposit is readily machinable
- Produces a higher strength Ni/Fe weld deposit making it preferable for dissimilar joints

Typical Applications

- Suitable for welding SG, nodular and malleable cast irons
- Ideal for welding cast iron to cast steels, can also be considered for welding some grades of austenitic irons [e.g. Ni Resist]

Conformances

AWS A5.15:

ENiFe-CI

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
3.2	350	579079-1	Linc Pack 1.0kg

Mechanical Properties

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Hardness HB10
Requirements - AWS	296-434	400-579	6-18	165-218
Typical Results - As Welded	300	460	10	180

Deposit Composition

	%C	%Fe	%Ni
All Weld Deposit	0.7	45	Bal

Typical Operation Procedures

Polarity	Current (amps)	
	3.2mm	4.0mm
AC/DC-	90-150	100-180