

Basic-graphite coated MMA electrode with a pure nickel core wire for welding cast iron without or with low preheating (max. +300 °C). For repair welding of cracked cast iron parts or joining components made of steel, copper or nickel materials to castings. Easy arc striking and restriking, stable arc, smooth bead surface. Weld short beads, about 30 to 50 mm long. In order to reduce weld residual stresses, hammer-peen welds slightly before cooling. Weld metal is machinable. Superfonte Ni is suitable for welding cast iron with lamellar graphite, white and black heart malleable and nodular cast iron.

Classification	
AWS	A5.15: ENi-CI
DIN	8573: E Ni BG - 22

Approvals	Grades

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
1.20	0.20	0.50	-	-	-	Rem	-	-	1	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	≥ 200	≥ 400	≥ 5	-	≥ 140 HB

### Materials

GG-10 - GG-35, GTS 35-10 - GTS 70-02, GGG-40 - GGG-70

GTW 35-04 - GTW S 38

### Storage and redrying

Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 80 °C for 1 hour, once only.

### Current condition and welding position

DC-; AC



### Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	350	50-80	18,1	10,9
3,2	350	80-110	32,1	19,2
4,0	350	110-150	47,0	28,2