

REPTEC CAST 1

MMA (SMAW)
REPAIR ELECTRODE
PRODUCT DESCRIPTION

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

CLASSIFICATIONS

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

WELDING POSITIONS (ISO/ASME)


PB/2F



PB/2F



PC/2G



PF/3Gu



PG/3Gd



PE/4G



PH/5Gu



PJ/5Gd

CURRENT TYPE

AC/DC +/-

CHEMICAL COMPOSITION (WIRE WT %)

	C	Fe	Ni
Min.	--	--	85
Max.	0.20	8.0	--
Typical	0.7	2.0	97

ALL-WELD MECHANICAL PROPERTIES

As welded	AWS A5.15	ISO 1071	Typical
Tensile strength (MPa)	276-448	250	445
0.2% proof strength (MPa)	262-414	200	270
Elongation (%)	3-6	3	8
Hardness HB10	135-218	--	175

TYPICAL OPERATING PARAMETERS, DC +VE OR AC (OCV: 50V MIN)

Diameter (mm)	2.5	3.2	4.0
min. A	50	70	90
max. A	100	130	150

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				pack	carton	pack	carton
PE TUBE	2.5	300	400885	146	146	2.5	2.5
	3.2	350	400892	76	76	2.5	2.5
	4.0	400	400908	44	44	2.5	2.5

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.