

ROYAL CAST – N (E Ni Ci)

AWS : E Ni Ci EN ISO 1071 A EC Ni-Ci-1

Applications

It is suitable for welding of variety of cast iron like grey, S.G. iron components. Suitable for cold welding for engine components, Blocks, Pump casing, Impellers gears, Sprockets, Valve bodies, cast iron machine base, filling in sand

Characteristics on Usage

ROYAL CAST-N is an outstanding electrode depositing pure Nickel for machinable welding of cast iron. The weld deposit is soft and has good resistance to cracking. It is used for welding of cast iron to produce machinable weld deposits. It is an all position electrode gives excellent bonding of weld metal with cast iron or dissimilar metal parts.

Packing

Vaccum packing

CASTING ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Ni %	Fe %
2.00 Max	2.50 Max	4.00 Max	0.030 Max	Traces	85.00 Min	8.00 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	HARDNESS
300-400	150 VPN

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2	10	AC/DC (+)	40 - 60
3.15 x 350	2	10		80 - 110
4.00 x 350	2	10		90 - 130
5.00 x 350	2	10		140 - 180