

ENI 402 (Ni)

Coated Electrode for Cast Irons -

Standards

AWS/ASME SFA - 5.15	ENi-CI
EN ISO 1071	E C Ni - CI 3
TS EN ISO 1071	E C Ni - CI 3

Approvals & Certificates

GOST

Materials

DIN

GG 10 - GG 35

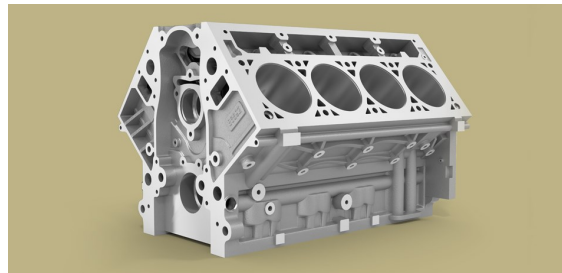
GTS 35-10 - GTS 70-02

GGG 40 - GGG 70

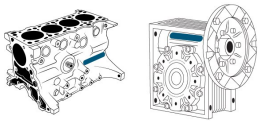
GTW 35-04 - GTW S 38-12

Properties and Applications

Electrode having a pure nickel core wire for welding cast iron without or with low preheating (max. 300°C). Suitable for welding cast iron with lamellar graphite, white and black heart malleable and nodular cast iron. Used also for repair welding of cracked cast iron parts or joining components made of steel, copper or nickel materials to cast irons. Weld metal is machinable. Provides easy arc striking and restriking, stable arc and 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. Preferably used with DCEP but possible to use also with AC.



Typical Applications



Typical Chemical Values of Weld Metal

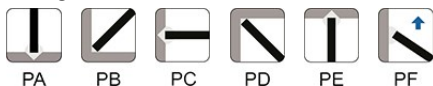
Type of Analysis	C	Si	Mn	Ni	Ti	Fe
Weld Deposit	0.40	0.45	0.20	97.50	0.45	1.00

Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HB)
As welded	160

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x300	50-70
3.25x300	90-110
4.00x400	110-140
5.00x400	140-200

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
16000G9EM1	2.50x300	15 pcs	0.29	40	11.80	Blister
16000GBEM2	2.50x300	59 pcs	1.11	10	0.00	
16000GDEM2	2.50x300	150 pcs	2.62	3	8.00	Plastic Box
16000GJEM2	2.50x300	105 pcs	1.79	9	16.30	VAC Box
16000M9EM1	3.25x300	10 pcs	0.33	40	13.20	Blister
16000MBEM2	3.25x300	36 pcs	1.11	10	0.00	
16000MDEM2	3.25x300	87 pcs	2.62	3	8.00	Plastic Box
16000MJEM2	3.25x300	61 pcs	1.79	9	16.30	VAC Box
16000RBEM2	4.00x400	30 pcs	0.00	10	0.00	
16000RJEM2	4.00x400	42 pcs	2.31	9	21.00	VAC Box
16000UJEM2	5.00x400	28 pcs	2.31	9	21.00	VAC Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
 It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.
 It has to be dried at 150°C for 1 hour.