

**SMAW**

# AceWeld 100Ni

## For Cast Iron

CLASSIFICATIONS: AWS A5.15 : ENi - CI  
JIS Z3252 : DFCNi

WELDING POSITIONS :



- **Basic, Graphite Coating**
- **Soft, Machinable Ni Deposit For The Welding of Cast Irons**

### DESCRIPTION AND APPLICATIONS

**AceWeld 100Ni** is a high grade maintenance purpose electrode with pure nickel core wire. This electrode tolerates low amperage settings and is suitable for both “cold” and “hot” welding of cast irons.

It produces a soft stable arc with minimal penetration and low spatter on both AC and DC sources. The ductile nickel based weld deposit is readily machinable with good color match to most cast irons.

Applications of **AceWeld 100Ni** includes repairing of cracks, filling of defects and joining of all kinds of cast iron and also suitable for welding of the construction which water tightening is required.

### TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	P	S	Fe	Ni
0.75	0.18	0.55	0.004	0.003	0.78	Bal

### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

TENSILE STRENGTH	ROCKWELL
304 N/mm <sup>2</sup>	HrB 75 - 85

- in condition.

### OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE (amps.)	PACKAGING (KG)		
			PKT	CTN	
2.6	300	50 - 80	1	2.5	20
3.2	350	70 - 110	1	2.5	20
4.0	350	100 - 140	1	2.5	20

- Recommended for DC + or AC (minimum 45 OCV) operation