



# Nickel Electrode for Welding Cast Iron AWS – ASTM - ENiCI

**AC or DC REVERSE (ELECTRODE+)**

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## GENERAL CHARACTERISTICS:

A high nickel content electrode with an extruded coating for welding cast iron. Welds are easily produced in all positions and the deposits are readily machined.

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## APPLICATIONS:

Used to join ordinary gray irons to themselves or to other ferrous and non-ferrous materials. Also for repair of castings when matching is to be done after welding. Welds can be satisfactorily produced on light and medium-size castings if there are not severe stresses or high phosphorus content encountered in the parent material.

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## TECHNICAL DATA:

Specifications .....	AWS A5.15 class ENi-CI			
	ASTM A398 class ENi-CI			
Nominal Chemical Composition % .....	Ni95.0, C-1.00, Mn-0.20, Fe-3.0, S-0.005, Si-0.70, Cu-0.10			
Current .....	AC or DC Reverse Polarity (Electrode+)			
Amperage .....	40-75	65-115	100-150	120-175
(in) .....	3/32	1/8	5/32	3/16
(mm) .....	2.5	3.25	4.0	5.0

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## PROCEDURES:

In most cases, preheating or post-heating will not be necessary but in cold weather or when special machining qualities are desired, the part should be preheated to 400° F (204° C). Stringer beads and intermittent welds should be employed to reduce stresses and cracks; peening while still hot also helps reduce these problems. Allow part to cool slowly.

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