



**MANUFACTURERS OF A DIVERSE RANGE OF
ADVANCED WELDING CONSUMABLES**

**SECTION
10**

WI-0304 DS142 CIN-1 Rev. 0, Date 01.09.2008

CIN-1	PURE NICKEL ELECTRODE FOR FULLY MACHINABLE, CRACK-RESISTING WELDS ON ALL GRADES OF CAST IRON			DATA SHEET NO. 142					
	SPECIFICATION	AWS A5.15	EN ISO 1071	JIS Z 3252					
CLASSIFICATION	ENi-CI	E C Ni-CI 3		DFCni					
PRODUCT DESCRIPTION	<p>The design emphasis of the chemically basic flux assures the metallurgical integrity of the weld metal. The high graphite content of the flux is expelled from the molten metal, compensating for the compression welding stresses thus preventing weld metal cracking.</p> <p>The core wire is pure nickel.</p>								
WELDING FEATURES OF THE ELECTRODE	<p>The arc is stable both AC and DC, but is very soft, thus minimising dilution. Weld beads are smooth, bright and evenly rippled. The slag is fairly fluid but relatively quick freezing, thus allowing smooth blends when edges are involved.</p> <p>The slag is readily controllable, thus making positional welding very easy, plus the slag is easily detachable.</p>								
APPLICATIONS AND MATERIALS TO BE WELDED	<p>Successful welding of cast irons is dependant on low strength weld metal and controlled heat input welding procedures. Both characteristics are assured by the use of CIN-1. CIN-1 may be used for all standard grades of grey cast iron and malleable cast irons.</p> <p>Typical applications include repairs to engine blocks and heads, gear housings, machine bases, as well as repairs to used castings. Is also used to rectify casting defects on new castings.</p>								
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Fe	Ni	Others
	MIN	-	-	-	-	-	-	85	-
	MAX	2.0	2.5	4.0	0.03	-	8.0	-	1.0
	TYPICAL	1.0	0.01	0.3	0.001	0.01	0.55	Bal.	0.05
WELD METAL PROPERTIES (ALL WELD METAL)	<u>PROPERTY</u>	<u>UNITS</u>	<u>MINIMUM</u>	<u>TYPICAL</u>	<u>OTHERS</u>				
	Tensile strength	N/mm ²		275					
	0.2% Proof stress	N/mm ²		-					
	Elongation on 4d	%	-	8	HV 140 -160				
	Reduction of Area (RA)	%	-	-					
	Impact energy-not applicable	J	-	-					
WELDING AMPERAGE AC or DC	Ø (mm)	2.6	3.2	4.0					
	MIN	50	70	100					
	MAX	80	110	140					
OTHER DATA	Electrodes that have become damp should be re-dried at 110°C for 1hour.								
RELATED PRODUCTS	Please contact our Technical Department for detail.								