

# AMERIARC

## Ameri Cast (60% Nickel)

### INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.15 E NiFe-CI-A  
ISO 1071: ENiFE

DIN 8573: E NiFe-1 BG23

### DESCRIPTION & APPLICATION:

**Ameri Cast (60% Nickel)** Universal electrode for joining a wide variety of ductile, nodular and malleable cast irons. Ideally suited for the repair of meehanite dies. Non-overheating, hard driving, Ferro-Nickel electrode for penetrating dirty-rusty contaminated cast irons.

Excellent for joining cast iron to steel. Extremely strong arc drive penetrates surface contaminants. Special slag composition can be welded over without creating porosity. Extra nickel content insures crack resistant machinable welds.

### WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

C	S	Mn	P	Si	Al	Cu	Fe	Misc	Ni
1.9	.030	<2.3	--	3.8	.97	.6	<45	1.9	ba1

**Flux Color :** Black

### TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	74,000 PSI (550 MPa)
Yield Strength	54,000 PSI (390 MPa)
Elongation	22%
Hardness	Brinell 180

### WELDING CURRENT & INSTRUCTIONS:

**Recommended Current :** DC Reverse (+), or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	50	40	100
Maximum Amperage	80	110	140

### PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
	Length (mm)	12" (300)	14" (350)	14" (350)
Packaging	Electrodes / lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0