

AMERIARC

Ameri Pure Cast

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.15 E Ni-CI
ISO 1071: E Ni

DIN 8573: E Ni BG 11

DESCRIPTION & APPLICATION:

Ameri Pure Cast is the high quality 99% nickel cast iron electrode featuring a totally non-conductive flux coating. Very soft machinable welds on all weldable cast irons.

It is suitable for joining mild steel to cast iron and is ideal for maintenance repair where sound welds are required, and excellent machinability.

WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

C	Mn	Si	S	P	Cu	Fe	Al	Misc	Ni
1.88	2.46	<4.0	.030	--	1.77	>4	.93	1 Max	Bal

Flux Color : Black

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	55,000 psi (380 MPa)
Yield Strength	38,000 psi (270 MPa)
Elongation	30%
Hardness	Brinell 155

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	70	80	130
Maximum Amperage	90	120	160

PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	2.5	3.25	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