



# HILCO PURE NICKEL

Stick electrodes – repair & maintenance – cast iron

EN ISO 1071: E C Ni-CI 1

AWS A5.15: E Ni-CI

**Coating type:**  
Basic

**Current:**



**Welding positions:**



Pure Nickel is our basic coated electrode for cold welding grey and malleable cast iron grades and for joining these base metals to steel, copper and copper alloys. The electrode deposits a high-grade pure nickel weld metal: ideal for repair welding cracked and worn castings including highly contaminated cast materials. Both weld metal and HAZ are soft and easily machine able using files. Pure Nickel is ideally suited for the combined welding with Nickel Iron (E NiFe-CI), buttering with Pure Nickel and filling with Nickel Iron.

## Base materials to be welded:

- Lamellar grey cast irons GG10 to GG40
- Malleable cast irons GTS35-GTS 60, GTW35-GTW60
- Joining and repairing
- Dissimilar joining cast iron to steel, copper, copper alloys

## Applications:

- Repair & Maintenance

## Chemical composition, wt. % weld metal – typical:

C	Mn	Si	Ni	Cu
0,7	1,0	0,3	balance	0,6

## Mechanical properties, weld metal – typical:

Condition	Tensile strength MPa	Elongation Lo=5d - %	Hardness
As welded	400	8	Approx. 160 HB

## Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	20,0	55-60
3,2	350	33,9	80-90
4,0	350	51,3	100-120