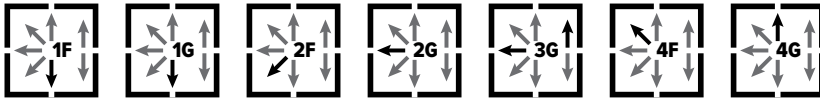


CAST IRON

HYPERARC  **ARC** Ni98



Summary

HYPERARC Ni98 are cast iron electrodes with a high nickel content specifically tailored for the welding of nodular cast iron and the repair of cast iron components. They yield a soft, pure nickel deposit, which provides exceptional machinability and diminishes the risk of weld cracking. This makes them especially suitable for applications requiring a high level of ductility in the weld metal. The Ni98 electrodes ensure consistent arc stability and are perfect for jobs that require the utmost weld metal toughness.

Typical Applications

- Welding of nodular cast iron
- Repair of cracks and broken cast iron parts
- Joining cast iron to steel
- Machinery parts and housings
- Repair of foundry defects

Classification

- AS/NZS 1553

Standards

- AWS A5.15 ENi-CI
- AWS/ASME SFA5.15: ENi-CI
- AS/NZS 1553: E-Ni98

Packaging Info

SKU	ELECTRODE SIZE	WEIGHT	DESCRIPTION
U63026	2.6mm	1kg	HYPERARC NI 98 CAST IRON ELECTRODES 2.6MM 1KG
U63027	3.2mm	1kg	HYPERARC NI 98 CAST IRON ELECTRODES 3.2MM 1KG

Operating Polarity

- AC & DCEP

Operating Data

ELECTRODE SIZE	WELDING CURRENT RANGE
2.6mm	60A-90A
3.2mm	80A-120A

Typical Chemical Composition (%)

C	Mn	Si	Ni	Mo	Cu
0.480	0.150	0.009	97.900	0.002	0.003
Al	Fe				
0.004	0.067				

Typical Mechanical Analysis

YIELD STRENGTH	302
TENSILE STRENGTH	350