



M-90 ENi-CI

FEATURES

- *HIGH-STRENGTH ARC-SUBMERGE WELDING WIRES IN SERIES
- *HIGH-STRENGTH COPPER-PLATING
- *COMMON ELECTRODES

APPLICATION

- *Special electrode for depositing soft machinable metal on grey cast iron.
- *Excellent for repairing casting defects in grey cast iron.
- *Can join cast irons to steels, monels etc.

CLASSIFICATION

- *A5.15/ ASME SFA5.15 Eni-CI

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	Fe	Ni	MO
1.35	0.78	0.35	0.004	0.003	0.55	96.0	

HARDNESS

Hardness (HRB)
77

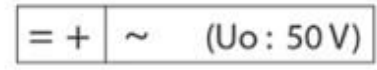
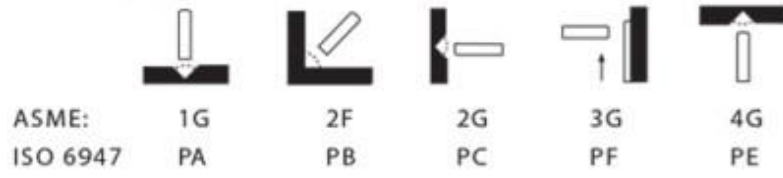
WELDING PARAMETERS

DIAMETER (mm)	2.5	3.2	4
LENGTH (mm)	350	350	350
CURRENT (amps)	55-80	80-110	90-135

CURRENT

- *AC or DC +/-

WELDING POSITIONS



Current