



AWS A5.15 ENi-CI
JIS Z3252 DFCNi

Characteristics:

LKE-Ni-CI is a covered electrode with graphite type coating and pure Ni alloy core rod. The weld metal provides excellent machining property, good tensile strength and good crack resistance.

Applications:

It is suitable for the repair welding of high pressure parts and cast iron products, etc

Notes on Usage:

- 1.Hot peening to prevent the shrinkage stress.
- 2.Clean up to prevent the contamination.
- 3.Preheat is not needed.
- 4.Use small amperage and keep the arc as short as possible.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Ni	Fe
1.07	0.16	1.57	0.005	0.005	92.4	4.5

Welding position:



Sizes and recommended current range

Diameter (mm)	2.6	3.2	4.0	5.0
Length (mm)	300	350	350	350
Current Range	60-80	70-120	100-150	130-170
Weight per pack(kg)	5	5	5	5
Weight per carton (kg)	20	20	20	20