

Applications

S-NCI can be used for repairing cast iron and joining of various kinds of cast iron products such as cylinder covers, motor beds, casings and gears. Repairing of meehanite, alloy and malleable cast iron.

Characteristics on Usage

S-NCI is a graphite type coated electrode, depositing nickel weld metal. Hardening of heat affected zone is small and machining of the welds is comparatively easy. Therefore it is suitable for welding alloy cast iron of poor weldability, malleable cast iron and hydraulically pressured parts as well as common cast iron.

Notes on Usage

- ① Chip off base metal completely at the repairing part.
- ② There is a possibility that cracks spreads or makes holes at both ends of repairing part.
- ③ Keep the weld metal length less than 50mm(2 inch) to disperse welding heat. Adopt back stepping stone or symmetry method by turns.
- ④ Hot peen in every pass.
- ⑤ The preheat temperatures vary in accordance with the size, kind and shape of the base metal. 150°C(302°F) is appropriate in general.

Welding Position

Current



1G 2F
(PA) (PB)

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Fe	Ni
1.38	0.79	0.36	0.004	0.003	0.58	98.3

Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Hardness (HRB)
-	77.6

Approval

I Packing

Packet 2.5 kg (5.5 lbs)
Carton 2.5 kg (5.5 lbs) × 4 : 10kg(22 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)
Length mm(in)	300 (12)	350 (14)	350 (14)
F	58~80	80~130	110~160