

# ENI 402 (Ni)

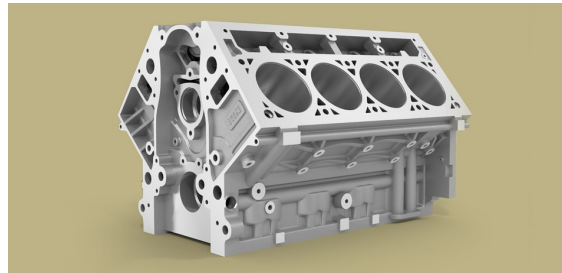
*Coated Electrode for Cast Irons -*

Standards	
AWS/ASME SFA - 5.15	ENi-CI
EN ISO 1071	E C Ni - CI 3
TS EN ISO 1071	E C Ni - CI 3

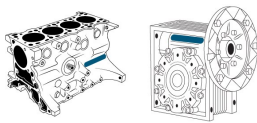
Materials
<b>DIN</b>
GG 10 - GG 35
GTS 35-10 - GTS 70-02
GGG 40 - GGG 70
GTW 35-04 - GTW S 38-12

## Properties and Applications

Electrode having a pure nickel core wire for welding cast iron without or with low preheating (max. 300°C). Suitable for welding cast iron with lamellar graphite, white and black heart malleable and nodular cast iron. Used also for repair welding of cracked cast iron parts or joining components made of steel, copper or nickel materials to cast irons. Weld metal is machinable. Provides easy arc striking and restriking, stable arc and smooth bead surface. Weld short beads, about 30 to 50 mm long. In order to reduce weld residual stresses, hammer-peen welds slightly before cooling. Preferably used with DCEP but possible to use also with AC.



## Typical Applications



## Typical Chemical Values of Weld Metal

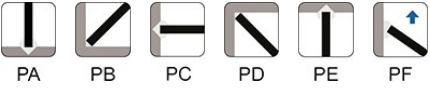
Type of Analysis	C	Si	Mn	Ni	Ti	Fe
Weld Deposit	0.40	0.45	0.20	97.50	0.45	1.00

## Typical Mechanical Values of Weld Metal

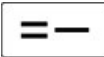

Test Condition	Hardness (HB)
As welded	160

## Application Information

Welding Positions



PA PB PC PD PE PF

Polarity:  

Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)	Weld Deposit(Kg)/1Kg Consumed Electrode	Number of Electrodes/1Kg Weld Deposit	Weld Metal Deposition Rate (Kg/h)	Efficiency(%)
2.50x300	50-70	0,68	88	0,5	107
3.25x300	90-110	0,68	51	0,59	110
3.25x350	90-110				
4.00x400	110-140	0,69	25	0,85	102
5.00x400	140-200	0,69	16	1,14	87

## Packaging Information

Product Code	Diameter X Length (mm)	Pieces per Box (-)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
16000GBEM2	2.50x300	59 kg	1.0	12	0.0	Plastic Box
16000GDEM2	2.50x300	150 kg	2.5	3	8.0	Plastic Box
16000GJEM2	2.50x300	105 kg	1.8	10	18.0	VAC Box
16000MBEM2	3.25x300	36 kg	1.0	12	0.0	Plastic Box
16000MDEM2	3.25x300	87 kg	2.5	3	8.0	Plastic Box
16000MJEM2	3.25x300	61 kg	1.8	10	18.5	VAC Box
16000NJEM2	3.25x350	60 kg	2.0	10	0.0	VAC Box
16000RBEM2	4.00x400	30 kg	1.8	10	19.0	Plastic Box
16000RJEM2	4.00x400	39 kg	2.3	9	21.0	VAC Box
16000UJEM2	5.00x400	28 kg	2.3	9	21.0	VAC Box

## Storage &amp; Re-Drying Information

It can be dried maximum 5 times.  
It has to be dried at 150°C for 1 hour.