



# RASI Ci Ni

## CAST IRON WELDING ELECTRODES

### TECHNICAL SPECIFICATION SHEET

#### CAST IRON ELECTRODE

RASI - Ci - Ni

PURE NICKLE WITH M/C DEPOSIT

#### CLASSIFICATIONS

AWS / SFA E Ni - Ci

#### CHARACTERISTICS

RASI - CI - Ni is a Medium coated pure Ni wire for specially designed for welding for known and unknown cast iron base metal, the Ni deposit does not pick up CARBON from the base Metal.

#### APPLICATIONS

RASI - Ci - Ni is used for Welding of all types of cast irons (known and unknown CI)  
Cast iron to mild steels joining.  
Rectification of defective castings.

#### SUGGESTED WELDING PROCEDURE

Use short arc and stringer bead not longer than 70mm Peen each bead and remove slag thoroughly for stress relieve Ensure the Welding not to hot the base metal.

#### CHEMICAL COMPOSITION OF ALL WELD METAL

ELEMENT	C	Fe	Ni	S	P
PERCENTAGE	0.8-0.15	1-2	95-98	0.03	0.03

#### MECHANICAL PROPERTIES OF ALL WELD METAL

U.T.S. Kgf/mm <sup>2</sup>	UTS N/mm <sup>2</sup>
30-40	300-400

Note : Single Values shown above are maximum

#### WELDING CURRENT : AC 70 V / DC(+)

Dia (mm)	2.5 x 350	3.15 x 350	4 x 350	5 x 350
Current (A)	50-70	70-100	100-120	140-150

PACKING : 1 Kg/pkt x 12 pkts = 12 kgs/Box

storage - Store in warm and dry place. If damped re dry at 100-110°C for 30 minutes.

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