

Product group: 096 Product number: 699504

Electrode for welding of cast iron with pure nickel.



Product information

This product supersedes product no: 606451

Nickel electrodes (95% Ni) for welding of gray cast iron to itself or to steel. Especially good for old oil-soaked and corroded cast iron, and also for joining cast iron to steel, copper, copper alloys and stainless steel.

The two types of UNITOR cast iron welding electrode i.e., Nickel-333N (Pure Nickel) and NiFe-334N (Nickel Iron) whereby the pure nickel grade will produce a softer, more malleable weld deposit or lower strength and ductility than those of nickel iron.

Hence, Nickel-333N should be used where maximum machinability of weld deposit is required or where low concentration of weld stresses e.g., these include applications for thin plates, machinery parts, frames and housings.

Features

- Unitor high density polyethylene packing
- Superb arc stability
- Easy slag removal and smooth weld surface
- Very good on oily cast iron

Benefits

- Long storage lifespan without moisture pick up
- Easy to use
- Little surface treatment needed
- Less porosity in deposit resulting in less required grinding

Specification

General

Invent Hazard Material (IMO/EU) classification	NA
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Dimensions/Weight

Diameter [mm]	3.2
Weight [kg]	2.2

Technical data

AWS	A5.15: E Ni-CI
Polarity	AC,DC+/-

Performance data

Amperage [A]	140
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Variants

Product name	Product number	Amperage [A]	Diameter [mm]	Weight [kg]
<u>NICKEL-333N 2.5X300MM 121PCS 2.0 KG</u>	699496 (supersedes 602946)	110	2.5	2
<u>NICKEL-333N 3.2X350 68 PCS 2.2 KG</u>	699504 (supersedes 606451)	140	3.2	2.2

Documents

[SDoC and MD for IHM](#)

Related products

Variants

699496
NICKEL-333N 2.5X300MM 121PCS 2.0 KG

Is frequently bought together with

233601
AG 60 252 2.0 X 500MM 0,5KG

699165
GPO-302N 2.5X350MM 295 PCS 5,2KG

699173
GPO-302N 3.2X350MM 190 PCS 5.4 KG

699272
LH-314N 3.2X450MM96 PCS 5KG

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