



S. R. Industries

STAR ARC ERNi-CI

ERNi-CI (Nickel Alloy 99) is used for TIG and MIG welding of cast iron. This wire is extensively used to repair gray iron castings. It can also be used for overlay and build-up applications. Dilution from the casting influences the mechanical properties of the metal. Due to the high nickel content, the welds are readily machinable. A preheat and interpass temperature of 350°F min is recommended during welding.

AWS Specification : AWS A5.15-90 (R2006)

<i>AWS Classification</i>	<i>ERNi-CI</i>
<i>Welding Current</i>	<i>DCEP</i>
Typical Wire Chemistry	
<i>C</i>	<i>1.0</i>
<i>Mn</i>	<i>2.5</i>
<i>Si</i>	<i>0.75</i>
<i>S</i>	<i>0.03</i>
<i>Fe</i>	<i>4.0</i>
<i>Ni</i>	<i>90 min</i>
<i>Cu</i>	<i>4.0</i>
<i>OTHER</i>	<i>1.0</i>
Typical Mechanical Properties (As Welded)	
<i>Yield Strength, ksi</i>	<i>36</i>
<i>Tensile Strength, ksi</i>	<i>66</i>
<i>Elongation%, min</i>	<i>40</i>
<i>Welding Positions</i>	<i>F,V,OH,H</i>

Address : C-617, DSIIDC, Narela, Delhi-110040 India

Tel : 011 47506585 **Mobile :** + 91 9911166585

E.Mail : srindus@yahoo.com

Website : www.stararc.in



S. R. Industries

<i>Available Diameters MIG and suggested Operating Range in Amps</i>	
<i>.035"</i>	<i>150 - 190</i>
<i>.045"</i>	<i>180 - 220</i>
<i>1/16"</i>	<i>200 – 250</i>
<i>Available Diameters TIG and suggested Operating Range in Amps</i>	
<i>.035"</i>	<i>60 - 90</i>
<i>.045"</i>	<i>80 - 110</i>
<i>1/16"</i>	<i>90 - 130</i>
<i>3/32"</i>	<i>120 - 175</i>
<i>1/8"</i>	<i>150 - 220</i>

Address : C-617, DSIIDC, Narela, Delhi-110040 India

Tel : 011 47506585 Mobile : + 91 9911166585

E.Mail : srindus@yahoo.com

Website : www.stararc.in