

## Coated Electrode for Cast Irons

### Classification

EN ISO 1071 : E Ni-CI 2  
 AWS A5.15 : ENi-CI  
 DIN 8573 : E Ni-BG 22

### General Description

AS Pik-98 Süper is a nickel cored electrode. It enables welding with drop arc metal transfer. It is used for the welding of all types of cast irons. It gives a very stable arc and a negligible amount of slag that can easily be removed. Heat effected zone is very narrow. Porosity free weld metal can be easily machined. It has excellent resistant to cracking.

### Chemical Composition (w%), Typical, All Weld Metal

C	Ni
1	balance

### Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 300 N/mm <sup>2</sup>
Tensile Strength	: 380 N/mm <sup>2</sup>
Elongation (L=5d)	: 8 - 10 %
Hardness	: 120 - 140 HB

### Approvals

GOST, SEPRO, TSE

### Applications and Materials to be Welded

AS Pik-98 Süper is particularly used for the joining and build up welding of gray cast iron, nodular cast iron and malleable cast iron parts. It is an ideal electrode for the joining of cast iron pieces to monel alloys, stainless and ordinary steels. It can also be used for filling up cavities in castings, or cavities that might form after machining.

When welding cast iron without preheat, the smallest possible electrode diameter should be selected to limit the width of the heat effected zone that might occur due to excess heating. When welding thick pieces, a preheating to 150-300°C and slow cooling is recommended.

Gray Cast Irons		Blackheart Malleable Cast Irons		Whiteheart Malleable Cast Irons	
DIN EN 1561	W. Nr.	DIN EN 1562	W. Nr.	DIN EN 1562	W. Nr.
GG 10	0.6010	GTS 35-10	0.8135	GTW 35-04	0.8035
GG 15	0.6015	GTS 45-06	0.8145	GTW 40-05	0.8040
GG 20	0.6020	GTS 55-04	0.8155	GTW 45-07	0.8045
GG 25	0.6025				
GG 35	0.6035				

### Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : AC min 40 V ; DC (-)

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
2.50	300	65 - 100	1810	0.6 / 35	2.0
3.25	300	90 - 130	2830	0.7 / 25	2.0
4.00	350	110 - 160	5082	2.8 / 55	2.5



1G/PA



2F/PB



2G/PC



3G/PF