



**PRODUCT INFORMATION**

**SIFTRODE CAST NI**

EN ISO 1071-A E C Ni-CI  
 AWS A5.15 E Ni-CI  
 DIN 8573 E Ni BG1

**DESCRIPTION**

Cast iron electrode with Ni pure core wire. Dedicated for cold welding grey and malleable cast iron and joining cast iron with steel. Welding is possible in all positions including vertical down.

**WELDING POSITIONS**



Welding Current: AC, DC+  
 Suitable positions: PA, PB, PC, PE, PF, PG

**TYPICAL WELD METAL COMPOSITION**

Ni	96.0 %
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**TYPICAL MECHANICAL PROPERTIES**

Ult Tensile Strength	≥ 300 N/mm2
Hardness	160 [HB]
Redrying	200° / 1h

**MATERIAL TO BE WELDED**

Grey cast iron, malleable cast iron

**AVAILABLE FORMATS**

ELECTRODE RODS (MMA / SMAW)			
Dia	1.0kg Pkt		Approx Pcs/KG
2.5mm	RE5002501		
3.2mm	RE5003201		
4.0mm	RE5004001		

CURRENT RANGE	
Dia (mm)	Amps
2.5	60-80
3.2	80-110
4.0	110-150

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email [service@wholeweld.co.uk](mailto:service@wholeweld.co.uk)

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