

	TECNHICAL DATA SHEET	FT-DQ69
	EUROTROD FN 10	PÁG. 1/1

CLASSIFICATION:

AWS A5.15: E Ni - CI

CERTIFIED COMPANY:



Management System
ISO 9001:2015

www.tuv.com
ID 1100008183



DESCRIPTION:

Nickel electrode for joining and surfacing of gray cast iron. Stable arc with clean bead appearance. Electrode provides crack resistant bead without pore formation. Chip forming machining process can be used. Weld induced stresses can be reduced by hammer peening.

SUITABLE FOR:

Repairing of parts in cast iron with lamellar graphite, white and malleable cast iron, nodular cast iron.

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:

Chemical Analysis (%):

Ni = 98 %

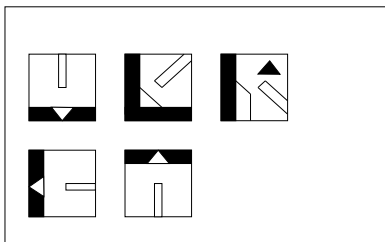
Mechanical Properties:

Hardness : 160 HB

PRODUCT INFORMATION:

WELDING PARAMETERS				VACUUM PACKING	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces /Packet (Un)	Weight /Packet (kg)
2,5	300	50 – 80	AC/DC	150	2,5
3,2	350	80 – 110	AC/DC	90	2,8
4,0	350	110 – 150	AC/DC	60	2,9

WELDING POSITIONS:



OBSERVATIONS:

Prior to welding, remove all traces of paint, grease, oil, rust and dirty. To avoid cracking induced by residual stresses or shrinka welding should be done at intervals, with frequent interruptions.
To avoid welding induced stresses, larger casting should slowly and uniformly preheated. After welding they should be cooled carefully and slowly (cover with hot sand if necessary).