



NEXA-116

ALLOY BASE : Ni, Cu.

SPECIAL FEATURES

- Excellent machinability and ductility.
- Best colour machining
- No pre-heating required.
- Nickel and copper alloy for good strength.

RECOMMENDATIONS

Easily machinable nickel copper alloy electrode for welding most of cast irons giving a high strength and sound joints.

APPLICATIONS

Broken cast iron parts, repairing defects in cast iron foundry, gear teeth, pump impellers etc.

PROCEDURES

Sufficient amount of the casting skin should be removed. Depending on the job thickness a U weld or a double U weld should be made. Use shortest possible arc length.

The pass width should not be more than twice the diameter of the core wire. Deslag every weld bead and peen the weld metal carefully. Restrike the arc on the weld metal and never on the parent metal.

TECHNICAL DATA

Tensile Strength : 30-34 kgf / mm²
Hardness 100 – 130 BHN

CURRENT RANGE : DC (-)

SIZE mm	2.50	3.15	4.00
CURRENT (Amps)	40-70	60-110	100-120