



Electrodes for Cast Iron | GEMINI Ni 98

GEMINI Ni 98 is a pure nickel electrode which is universally used for welding all types of cast iron. Specially to operate at low currents which minimizes heat input and thus facilitates the “cold welding” of cast iron. Weld induced stresses can be reduced by hammer peening. Stable arc with clean bead appearance. The weld metal is fully machinable.

TYPICAL ALL-WELD METAL PROPERTIES

COMPOSITION (%)		MECHANICAL	
C – Carbon	0.30	Vickers Hardness HV30	160 HV
Mn - Manganese	0.20		
Ni - Nickel	97.00		

TYPICAL WELDING CURRENT

AC or DC +				
Diameter /Length (mm)	2.6/ 300	3.2/ 350	4.0/ 350	5.0/ 350
Current min/ max (A)	50/ 80	80/ 110	110/ 150	150/ 190

INTERNATIONAL STANDARD

MARKINGS & IDENTIFICATION

AWS A5.15	E Ni-CI	End Tip Colour	Green
		End Side Colour	Green
DIN 8573	E Ni BG 1	Printing	G-Ni98/ E Ni-CI

WELDING POSITION

Flat, Horizontal, Vertical-up and overhead

PACKAGING & ORDERING INFORMATION

Size	Packet	Carton
2.6mm	1 kg	20 kgs
3.2mm	1 kg	20 kgs
4.0mm	1 kg	20 kgs
5.0mm	1 kg	20 kgs

Disclaimer: The information provided serves as a general guideline. Actual welding parameters may vary depending on the specific characteristics of the welding equipment. Additional variables to consider include weld length, plate thickness, operator proficiency, etc. Users are encouraged to assess their unique circumstances and seek professional advice as needed. It is important to acknowledge that neither we nor our affiliates can be held liable for any misuse or improper application of products.