

# HABCO CI 8099

## NICKEL ELECTRODE FOR WELDING CAST IRON

### FEATURES

**HABCO CI 8099** is a high nickel electrode for cold welding of cast iron. Welds are easily produced in all positions and the deposits are readily machined.

### APPLICATIONS

Used to join ordinary gray irons to themselves or to other ferrous and non-ferrous material. Also for repair of castings when machining is to be done after welding. Welds can be satisfactorily produced on light and medium size castings if there are not severe stresses or high phosphorus content encountered in the parent material.

### INSTRUCTIONS

In most cases preheating or post heating will not be necessary, but in cold weather or when special machining qualities are desired the part should be preheated to 400°F (204°C). Stringer beads and intermittent welds should be employed to reduce stresses and cracks; peening while still hot also helps reduce these problems. Allow part to cool slowly.

**Tensile Strength: up to 50,000 Psi (35 kg/mm<sup>2</sup>)**

**Elongation: up to 30%**

**Hardness: up to 175 Brinell**

**Current: AC or DC +**

<b>Amperage:</b>	<b>30-80</b>	<b>70-110</b>	<b>80-130</b>	<b>100-170</b>
<b>Diameters: (in)</b>	<b>3/32</b>	<b>1/8</b>	<b>5/32</b>	<b>3/16</b>
<b>(mm)</b>	<b>2.5</b>	<b>3.25</b>	<b>4.0</b>	<b>5.0</b>

- Conforms to AWS A5.15 ENiCl