

GEMINI Ni 98

Typical Applications And Characteristics

GEMINI Ni 98 is a pure nickel electrode which is universally used for welding all types of cast iron. Specially designed 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	0.30	Vickers Hardness HV30	160 HV
Mn	0.20		
Ni	97.00		

Typical welding current

AC or DC +				
Ø/L (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		Color	End	Green
AWS A5.15	E Ni-C1	Coding	Side	Green
DIN 8573	E Ni BG 1	Printing	G-Ni98/E Ni-C1	
		Welding Positions	Flat, horizontal, vertical-up and overhead	