

## GEMINI Ni 98

## AWS/SFA5.15/E Ni-CI

### *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	0.43	Yield Stress	300	N/mm <sup>2</sup>
Mn	0.15	Tensile Strength	400	N/mm <sup>2</sup>
Ni	97.80	Elongation	5	%
		Vickers Hardness HV30	130	HV

AC or DC ±				
∅/L (mm)	2.6X300	3.2X350	4.0X350	5.0X350
Current min/max (A)	50-80	80-110	110-150	150-190

Typical welding current			
Approval	Color	End	Green
TIS. 732-2531	Coding	Side	Green
	Printing	G-Ni98/E Ni-CI	
	Welding Positions	Flat, horizontal, vertical-up and overhead	