

Panzerchrom P-Tech[®] Cast Ni

Gas Shielded Solid Welding Wire - M&R Applications



Typical Applications

- Repairing of cracks, joining applications.
- Repairing surface imperfections, machining errors, hole filling.
- Rebuilding broken or missing sections.
- Repairing of gearboxes, frames of tool machines, reducing pieces, valve and pump bodies.

Standards

EN ISO 1071 S C NiFe 2

General Characteristics

P-Tech[®] Cast Ni is gas shielded, solid welding wire, developed for welding of ferritic and austenitic nodular cast iron as well as for joining it with unalloyed and high-alloyed steels, copper and nickel alloys.

Features & Benefits;

- Excellent weldability for single and multipass welds.
- Tough welding deposit.
- Crack resistant.
- Easily machinable with cutting tools.

Wear Resistance

Corrosion



Metal to Metal



Abrasion



Welding Positions, Polarity and Shielding Gas

Welding Positions : PA, PB
 Shielding Gas : EN ISO 14175- M12
 Polarity : DC (+)

Typical Mechanical Properties

Typical All Weld Metal Mechanical Properties

Tensile Strength : >300 MPa
 Yield Strength : >500 MPa
 Elongation (l=5d) : >25%
 Hardness : approx. 200HB

Packaging & Diameter Details

Product Code	Diameter (mm)	Packaging Options
-	1.20	15 Kgs Spools
-		
-		
-		
-		

Recommended Operating Parameters

Diameter (mm)	Current (A)	Voltage (V)
1.20	180 - 300	20-30

Storage Informations

Products should be stored in moisture free room on wooden, composit or plastic pallets.