



Zerock E90

Pure Nickel Electrode

◆ **Description:**

Superior graphite with nickel core electrode excellent for joining and build up in all cast iron. Fully machinable deposits, no undercut and high temperature resistance.

◆ **Applications:**

Repair of various kinds of cast iron product, cylinder head and engine block. Deposits nearly pure nickel which is easy machinables.

◆ **Classification:**

AWS ENI-CI

◆ **Typical Chemical Composition of Deposited Metal (%):**

<u>C</u>	<u>Mn</u>	<u>Al</u>	<u>Si</u>	<u>S</u>	<u>Ni</u>	<u>Cu</u>	<u>Fe</u>
1.12	0.81	0.02	1.01	0.012	93.0	0.05	REM.

◆ **Mechanical Properties of Deposited Metal:**

Tensile Strength	400 Mpa
Elongation	4.5%
Hardness	180BHN

◆ **Type of Current:**

AC or DC

◆ **Amperages Setting:**

2.5mm	100 – 130
3.2mm	140 - 150
4.0mm	160 – 170