Product names	Typical use & Redrying condition	AWS Class.	Pol.	WP		C	Si
CI-A1	▪ Repairing and joining various kinds of cast irons ▪ 70~100℃x0.5~1h	A5.15 ENi-CI	AC DCEP	F	Ty	1.0	0.1
					Gt [a]	2.0	4.0
CI-A2	▪ Repairing and joining various kinds of cast irons ▪ 70~100℃x0.5~1h	A5.15 ENiFe-CI	AC DCEP	F	Ty	1.1	0.3
					Gt [a]	2.0	4.0
CI-A3	▪ Repairing and joining various kinds of cast irons ▪ 300~350℃x0.5~1h	-	AC DCEP	F	Ty	0.04	0.50
					Gt [a]	0.15	1.00

Note: [a] Single values are maximum. Ty: Typical (polarity: AC), Gt: Guaranty

Identification color

Product names	1st	2nd
CI-A1	Gold	Red
CI-A2	Gold	Pink
CI-A3	Black	Orange

Composition (all-weld metal mass%)							All-weld mechanical properties	
Mn	P	S	Ni	Fe	Cu	Al	TS (MPa)	El on 4d (%)
0.6	<0.01	<0.01	Bal.	1.7	<0.1	<0.1	480	-
2.5	-	0.03	85min.	8.0	2.5	1.0	-	-
2.0	<0.01	<0.01	55	Bal.	<0.1	<0.1	520	-
2.5	-	0.03	45~60	Bal.	2.5	1.0	-	-
0.48	0.01	<0.01	-	Bal.	-	-	490	33
0.80	0.04	0.04	-	Bal.	-	-	-	-

Packaging data

ϕ mm	2.6	3.2	4.0	
CI-A1	-	350	350	-
CI-A2	300	300	350	-
CI-A3	300	350	-	400
carton mm	250W, 135H, 450L	250W, 120H, 440L	240W, 85H, 440L	170W, 115H, 430L