Fonte BMP

"Bimetal" Electrode DC+

For Cast Iron Welding

Classification

AWS A 5.15 : E NiFe-CI
ISO 1071 : E C NiFe-CI 1
DIN 8573 : E NiFe-1 BG 23

Description & Applications

Graphite-basic Barium free coating and «Bimetal» core wire with high electrical conductivity for cold welding of various cast iron types on DC+ or AC. The «Bimetal» core wire authorizes very important fusion speeds with direct current as well as with alternative current without any risk of overheating the electrode (phenomenon often noticed with conventional Ferro-Nickel electrodes).

Main applications: For repair and construction welding on all cast iron types and dissimilar joints between cast iron and steels.

Base materials

Grey cast iron, malleable and nodular cast iron

ASTM	DIN	NFA
A48 Class 25B-60B	GG-15 to GG-40	FGL 150 to FGL 400
A536 Grade 60-100	GGG-40 to GGG-70	FGS 400-12 to FGS 700-3
	GTS-35 to GTS-65	MN 350-10 to MN 650-3
A439 Type D-2	GGG-NiCr20-2	S-NC20-2

Typical Weld Metal Composition (%)

C	Si	Mn	Ni	Fe
0.8	0.8	0.3	55.0	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	Hardness
370	540	22	Approx. 180 HB

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	85	110	135

Weld on clean and exempt from grease surfaces (previous grinding of the joint). Apply a heat input as low as possible and keep the temperature low (<70°C). Weld with lowest practical current and depose short and narrow beads to reduce the risk of producing cracks in the base metal. To reduce stresses, produced during welding, hammering of the beads is recommended after the deposition of short runs (essential on rigid pieces).

ind.10

= +	~ 50V