



# Selectarc Fonte Fe

*Basic Coated Special  
Electrode for Cast Iron*

## Classification

AWS A 5.15 : ESt  
ISO 1071 : E C Fe-1 3

DIN 8573 : E Fe-1

## Description & Applications

Special iron base electrode for repair welding of poor quality, slag or oil containing old cast iron (furnace parts, boxes, heaters, pumps, ...). Smooth arc, deep penetration. Weld deposit can only be machined by grinding. For butt welding it is important to use Fonte-Fe only as initial bonding pass, then take Selectarc Fonte-Ni and Ferro-Ni to fill.

## Typical Weld Metal Composition ( % )

C	Si	Mn	Fe
0.13	0.9	0.5	Rem.

## All Weld Metal Mechanical Properties

Hardness  
Approx. 350 HB

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x350	3,2x350	4,0x450
Current	( A )	70-90	80-110	100-140

Use only dry electrodes. Redrying : 2h/250°C. Use a low amperage, maintain the arc short, deposit thin layers.

ind.12



= +,- ~ 70 V

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