Selectarc Fonte NiFe2

Ferro Nickel Electrode
Graphite-basic Coated

Classification

AWS A 5.15 : ENiFe-CI   DIN 8573 :   E NiFe-1 BG 12
ISO 1071   : E C NiFe-CI 1

Description & Applications

Graphite basic coated electrode with a Ferro-Nickel alloy deposit for joining and repairing nodular cast iron. Sound deposit, highly resistant against cracks. Particularly recommended for dissimilar welding of cast iron to steels and constructions of cast iron. Good bonding and flow of the weld metal.

Main applications: Repairing of defects in foundries, repairing of engine blocks, houses of tool machines, gearboxes, reducing parts, pump bodies, cast pieces, valve bodies.

Base materials

Grey cast iron, malleable and nodular cast iron :

ASTM	DIN	NFA
A48 class 25B to 60B	GG-15 to GG-40	FGL 150 to FGL 400
A536 Grade 60-80	GGG-40 to GGG-60	FGS 400-12 to FGS 600-3
	GTS-35 to GTS-65	MN350-10 to MN650-3

Typical Weld Metal Composition (%)

C	Si	Mn	Ni	Fe
1.7	1.4	0.7	55.0	Rem.

All Weld Metal Mechanical Properties

R_m (MPa)	Hardness
>400	Approx. 200 HB

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	70	100	145

Weld on clean and exempt from grease surfaces (previous grinding of the joint).Reduce the heat input to a minimum, weld with the lowest practical amperage, keep temperature low (< 100℃) in order to reduce the risk of cracks in the base metal, depose short beads of about 6 cm and peen immediately. Reignite on the weld metal –not on the casting.

ind.12

= -   ~ 40 V