

OK NiFe-CI



A nickel-iron electrode for welding normal grades of cast iron and for joining them to steel. Can be used for malleable nodular cast iron and alloy cast iron. It has a special iron jacketed Ni core wire, which gives the electrode much improved current carrying capacity compared to electrodes with a homogeneous core wire. The electrode produces a weld metal stronger and more resistant to solidification cracking than the pure nickel electrode types. Typical applications are repair of pump bodies, heavy machine sections, gear teeth, flanges and pulleys.

Specifications	
Classifications	SFA/AWS A5.15 : ENiFe-CI EN ISO 1071 : E C NiFe-1 3

Welding Current	AC, DC+
Alloy Type	Ni-Fe alloy
Coating Type	Basic Special high graphite
Min AC OCV	45

Typical Tensile Properties		
Condition	Yield Strength	Tensile Strength
ISO		
As Welded	380 MPa	560 MPa

Typical Weld Metal Analysis %						
C	Mn	Si	Ni	Al	Cu	Fe
0.9	0.6	0.5	53	0.4	0.9	44

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300 mm	60-100 A	22 V	70 %	45 sec	0.8 kg/h
3.2 x 350 mm	80-150 A	23 V	70 %	56 sec	1.2 kg/h
4.0 x 350 mm	100-200 A	23 V	70 %	59 sec	1.6 kg/h