



FERRICAST

CLASSIFICATIONS

AWS A/SFA 5.15 E Ni Fe-CI
 IS 5511 E Ni Fe G16

COATING FACTOR: Medium IDENTIFICATION: Brand Printed

CURRENT CONDITIONS: AC, DC (+)			
5.0	4.0	3.2	2.5
140-	90-	70-	40-
180	120	110	70

CHARACTERISTICS

An electrode with Ferro Nickel core wire specially designed for welding cast iron the cold way. The nickel-iron weld deposit does not pick up carbon from the base metal and hence remains ductile, soft and easily machinable, at the same time retaining adequate strength. This permits successful use of the electrode without the necessity of preheating even on large complicated castings.

WELDING POSITIONS
 F

REDRYING CONDITIONS

150°C for 1 hour

(Optionally also available in vacuum-packed condition, redrying not required in this packaging)

TYPICAL APPLICATIONS

Because of easy and intimate fusion with all grade of cast iron the electrode is best suited for welding and repairing all cast iron components. Successful applications include repair of broken castings, building up of worn surfaces or correcting machining errors on castings and joining cast iron to steel. Welding of nodular graphite iron, malleable iron subject to heavy wear

MECHANICAL PROPERTIES- ALL-WELD		
Condition	UTS MPa	Hardness BHN
AW	320-430	175-200

AW : As-welded

WELD METAL CHEMISTRY, WT%		
C - 2.0 max.	Cu - 2.5 max.	S - 0.03 max.
Mn - 1.0 max.	Ni - 45.0-60.0	Fe- Rem.
Si - 4.0 max.	Al - 1.0 max.	P - 0.03 max.

PACKING DATA			
Dia.,mm	4.0	3.2	2.5
Length,mm	300	300	300
Wt. per carton, kgs	6	6	6
Cartons/ box	3	3	3
Wt. per box, kgs	18	18	18