

FERRICAST

AWS A/SFA 5.15 ENiFe-CI

CAST IRON

CLASSIFICATION:

ISO 1071
E C NiFe-11

IS 5511
E Ni Fe CC23

KEY FEATURES:

- Ni-Fe type machinable electrode
- Dense, soft and ductile weld with adequate strength
- Porosity free welding
- Controlled dilution and penetration
- No need of preheating for large heavy castings

APPROVALS: CE

TYPICAL APPLICATIONS:

- Repair of broken heavy castings
- Welding and repairing of all cast iron components
- Pump casting and gears, Cast iron dies, Gear boxes, Gear teeth
- Transmission housings, Couplings
- Foundry defects, Machine build up
- Best suited for welding of Nodular graphite iron, Malleable iron subject to heavy wear
- Joining cast iron to steel
- Correcting machining errors on castings



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Fe	Ni
1.1	1.2	1.5	47	51

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	3 Layer, Hardness, BHN
Specification	As Welded	190 max

PARAMETERS - PACKING DATA:

Ø x L, mm 2.5 x 350 3.15 x 350 4.0 x 350	Amperage, A 40-70 70-110 90-120	 AC (70 OCV)/ DCEP REDRYING CONDITION: 150°C for 1 hr.	All Positions, except vertical Downwards 
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Available in Standard carton packing of 10 kg box containing 1 cartons of 10 kgs each.