



FERRICAST

CAST IRON



Ni-Fe Type Electrode for Repair and Welding of Cast Iron

CLASSIFICATION : AWS A/SFA 5.15

IS 5511

E NiFe-CI

E Ni Fe G16

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

WELDING POSITION :



AC (45 OCV)/ DCEP

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

REDRYING CONDITION : 150°C for 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Ni	Fe	Mn	Si	S	Cu	Al
Typical	1.1	52.0	Bal.	1.2	1.5	0.02	0.5	0.3
Specification	2.0 max	45.0-60.0	Bal.	2.5 max	4.0 max	0.03 max	2.5 max	1.0 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	Hardness (3 Layer), BHN
Specification	As Welded	150-190

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg
2.5 x 300	40-70	1	10	10
3.15 x 300	70-110	1	10	10
4.0 x 300	90-120	1	10	10

