

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.

Classifications:	SFA/AWS A5.15:ENiFe-CI, EN ISO 1071:E C NiFe-1 3
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Welding Current:	AC, DC+
Alloy Type:	Ni-Fe alloy
Coating Type:	Basic Special high graphite

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	380 MPa	560 MPa	>15 %

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	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 300 mm	60-100 A	22 V	0.70	85.0	45 s	0.80 kg/h
3.2 x 350 mm	80-150 A	23 V	0.70	44.0	56 s	1.20 kg/h
4.0 x 350 mm	100-200 A	23 V	0.70	30.0	59 s	1.60 kg/h