

**Standards :**

TS 9463 EN ISO 1071 :	E C NiFe Cl 1
EN ISO 1071 :	E C NiFe Cl 1
AWS A5.15 :	E NiFe-Cl

**Chemical Composition of Weld Metal-  
% (Typical) :**

Ni	Fe
>45.0	>40.0

**Mechanical Properties :**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation (L <sub>0</sub> =5d <sub>0</sub> )(%)	Hardness (HB)
200	350	6	-190

**Typical Base Material Grades :**

- \* Welding of grey cast iron, temper cast iron.
- \* Joint welding of cast iron with hard-to-weld steels or cast parts.
- \* Ni-Fe cored stick electrode.
- \* Welding in short passes, and hammering the bead of each pass through gentle strikes are required.

**Welding Positions :**



**Current Type :**

D.C.(+)

**Operating Data :**

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.50 x 300	3/32 x 12"	60 - 90	1590
3.20 x 300	1/8 x 12"	80 - 120	2700
4.00 x 400	5/32 x 16"	110 - 150	5380

**Approvals :**

TSE, CE, GOST-R, SEPRO