

Brand Name & Classification

AWS/ASME SFA-5.15: E NiFe-CI
DIN 8573: E NiFe-1 BG-22

Properties

Electrode having a Nickel Iron core wire, suited for welding of cast iron and for joining cast iron parts to steel, copper and nickel. It features higher strength properties than pure nickel weld metal and is therefore suited for joining nodular cast iron, malleable cast iron and austenitic nodular cast iron.

Application

Nodular cast iron
White & black heart malleable cast iron
Austenitic nodular cast iron

Weld Metal Analysis Typical values

Carbon: 0.50

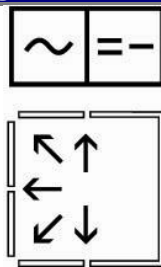
Iron: Balance

Nickel: 55.0

Typical Mechanical properties

| Yield Strength | Tensile Strength | Elongation | Impact Strength |
|----------------|------------------|------------|--------------------|
| >300 N/MM2 | 420 - 460 N/mm2 | > 10 % | Hardness HB 170 |

Welding Current & Positions



Current

| Dia | Length | Amperes |
|-----|--------|---------|
| 2.6 | 300 | 60-80 |
| 3.2 | 350 | 80-120 |
| 4.0 | 350 | 110-150 |