



FERRICAST

CAST IRON

AWS A/SFA 5.15 ENiFe-CI

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

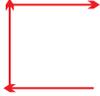
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Fe	Ni
1.1	1.2	1.5	47	51

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS, MPa	EL, %	Hardness, BHN
Specification	As Welded	400-579	296-434	6-18	165-218

PARAMETERS - PACKING DATA:

$\varnothing \times L$, 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	All Positions, except vertical Down 

Available in Standard carton packing of 10 kg box containing 1 cartons of 10 kg each.