

Product Data Sheet

Ferro nickel electrode

SUPERCAS^T NiFe

Classification **AWS A 5.15:** E NiFe-CI **DIN 8573:** E NiFe- 1 BG11 **ISO 7071:** NiFe 1

Description and applications Graphite basic coated electrode with a Ferro-Nickel alloy deposit for joining and repairing nodular cast iron. Deposit homogeneous, machinable and highly resistant against cracks. Particularly recommended for dissimilar welding of cast iron to steels and constructions of cast iron. Good bonding and flow of the weld metal. Defect in foundries, repairing of engine blocks, houses of tool machines, gearboxes, reducing parts, pump bodies, cast pieces, valve bodies.

Base materials **Grey cast iron, malleable and nodular cast iron:**

ASTM	DIN	NFA
: A48 class 25B to 60B : A536 Grade 60-80	: GG-15 to GG-40 : GGG-40 to GGG-60 : GTS-35 to GTS-65	: FLG 150 to FLG 400 : FGS 400-12 to FGS 600-3 : MN350-10 to MN650-3

Typical weld metal Chemical Composition (%)

Ni	FE & OTHERS
55.00	BALANCE

All weld metal mechanical properties (typical)

Tensile strength R _m (N/mm ²)	Hardness
> 480	190 HB

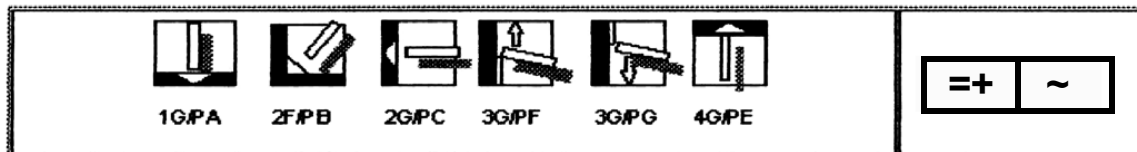
Amperes (A)

2.40mm	2.50mm	3.15mm	3.25mm	4.00mm
50-70	50-70	70-90	80-100	100-130

Welding instruction

Reduce the heat input to a minimum, keep temperature low (maxi temperature 70°C) in order to reduce the risk of cracks in the base metal. Depose short beads of about 3 cm and peen immediately. Reignite on the weld metal. Weld on clean and exempt from grease surfaces (previous grinding of the joint).

Welding position



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