

ENiFe-CI

AWS A5.15 ENiFe-CI
GB/T10044 EZNiFe-1

Description:

A nickel-iron type electrode designed to weld normal grades cast irons and joint them to steel, It has very good current-carrying capacity and the weld metal is stronger and more resistant to solidification cracking than other nickel type electrodes . Used for the repairing of high strength gray cast iron and nodular cast irons.

Welding Position:



Diameters:

2,5mm, 3,2mm, 4,0mm, 5,0mm.

Typical Chemical Compositon:

C	Mn	Si	S	Cu	Ni	Fe
1.17	1.2	0.80	0.003	0.01	Bal	54

Welding Current:(AC/DC+)

Diameter(mm)	2,5	3,2	4,0	5,0
Current/A	-	95-120	150-180	190-220

Note:

The electrodes must be baked 1 hours in 150°C before using.