

# ENiFe-CI

CAST IRON WELDING ELECTRODE  
WITH NON-MACHINABLE WELD, N 55



## CHARACTERISTICS

1. Ni-Fe Type cast iron welding ELECTRODE
2. Non-machinable weld bead
3. Porosity free welding
4. Controlled dilution and penetration
5. No need of preheating for large heavy castings

SIZE	AMPS
4.0mm	90-120A
3.20mm	70-110A
2.50mm	40-70A

## CLASSIFICATION

AWS A5.15 ENiFe-CI  
EN ISO 1071 E C NiFe-CI

## PACKING SPECIFICATION

1kg Vacuum Pack with Plastic Tube

## CURRENT TYPE

AC/DC+

## AVAILABLE SIZES (DIA./LENGTH)

2.5mm\*350mm  
3.2mm\*350mm  
4.0mm\*400mm

## EQUIVALENT TO

Lincoln RepTec Cast 3  
Esab OK 92.58  
Hyundai S-NFC  
Kiswel KFN-50

## TYPICAL APPLICATIONS

1. Repair of broken heavy castings
2. Welding and repairing of all cast iron components
3. Pump casting and gears, Cast iron dies, Gear boxes, Gear teeth
4. Transmission housings, Couplings
5. Foundry defects, Machine build up
6. Best suited for welding of Nodular graphite iron, Malleable iron subject to heavy wear
7. Joining cast iron to steel
8. Correcting machining errors on castings

## CHEMICAL COMPOSTIONS (Wt%), ALL WELD METAL, TYPICAL

C	Si	Mn	Ni
1.17	0.50	1.50	54.0

## MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

Condition	0.2% Proof Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Hardness (HV)
AW	385	245	10	180

## Note:

- ① Residual stresses are decreased by peening after each layer.
- ② Cold welding, interpass temperature <100°C.
- ③ Heavy parts preheat (to max. 300°C).

