

OK NiFe-CI

A nickel-iron electrode for welding normal grades of cast iron and for joining them to steel. Can be used for malleable nodular cast iron and alloy cast iron. It has a special iron jacketed Ni core wire, which gives the electrode much improved current carrying capacity compared to electrodes with a homogeneous core wire. The electrode produces a weld metal stronger and more resistant to solidification cracking than the pure nickel electrode types. Typical applications are repair of pump bodies, heavy machine sections, gear teeth, flanges and pulleys.

Specifications

Classifications	SFA/AWS A5.15 : ENiFe-CI EN ISO 1071 : E C NiFe-1 3
Welding Current	AC, DC+
Alloy Type	Ni-Fe alloy
Coating Type	Basic Special high graphite

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength
ISO		
As Welded	380 MPa (55 ksi)	560 MPa (81 ksi)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Al	Cu	Fe
0.9	0.6	0.5	53	0.4	0.9	44

Deposition Data

Diameter	Current	Voltage	Deposition Efficiency (%)	Burn-off Time /Electrode	Deposition Rate @ 90% I max
2.5 x 300.0 mm (0.098 x 11.8 in.)	60-100 A	22 V	70 %	45 sec	0.8 kg/h (1.8 lbs/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	80-150 A	23 V	70 %	56 sec	1.2 kg/h (2.6 lbs/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	100-200 A	23 V	70 %	59 sec	1.6 kg/h (3.5 lbs/h)