OK NiFe-CI-A

A nickel-iron cored electrode for joining normal grades of cast iron, such as grey-, ductile- and malleable irons. It is also suitable for rectification and repair of these grades and for joining them to steel. Deposition is done on cold or slightly preheated cast iron. The electrode produces a weld metal stronger and more resistant to solidification cracking than that of the pure nickel electrode type. It is specially suited for high duty welds in ductile irons and for welding grey irons with increased contents of sulphur and phosphorous. Typical applications include repair of pump bodies, heavy machine sections, gear teeth, flanges and pulleys.

Classifications	SFA/AWS A5.15 : ENiFe-CI-A EN ISO 1071 : E C NiFe-CI-A 1
Approvals	CE : EN 13479

Welding Current	AC, DC+-
Alloy Type	Ni-Fe alloy
Coating Type	Basic Special high graphite

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Al	Fe
1.5	0.8	0.7	0.003	0.006	51	1.4	46

Deposition Data

Diameter	Current	Efficiency (%)	Number of electrodes /kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300.0 mm	55-75 A	70 %	90	70 sec	0.6 kg/h
3.2 x 350.0 mm	75-100 A	70 %	45	90 sec	0.9 kg/h
4.0 x 350.0 mm	85-160 A	70 %	30	70 sec	1.8 kg/h