

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.

Klasifikácie	SFA/AWS A5.15 : ENiFe-CI EN ISO 1071 : E C NiFe-1.3
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Zvárací prúd	AC, DC+
Typ zliatiny	Ni-Fe alloy
Typ obalu	Basic Special high graphite

Typické pevnostné vlastnosti

Stav	Medza klzu	Pevnosť v ťahu
ISO		
Po zvarení	380 MPa	560 MPa

Typical Weld Metal Analysis %

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

Naváracie údaje

Priemer	Prúd, A	V	Počet elektród/zvarový kov	Doba odhorievania elektródy	Účinnosť %	Deposition Rate @ 90% I max
2.5 x 300.0 mm	60-100 A	22 V	85.0	45 sec	70 %	0.8 kg/h
3.2 x 350.0 mm	80-150 A	23 V	44.0	56 sec	70 %	1.2 kg/h
4.0 x 350.0 mm	100-200 A	23 V	30.0	59 sec	70 %	1.6 kg/h