

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.

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

Schválenie je platné podľa miesta výroby. Prosím kontaktujte ESAB pre ďalšie informácie.

Zvárací prúd	AC, DC+-
Typ zliatiny	Ni-Fe alloy
Typ obalu	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

Navráacie údaje

Priemer	Prúd, A	Počet elektród/zvarový kov	Doba odhorievania elektródy	Účinnosť %	Deposition Rate @ 90% I max
2.5 x 300.0 mm	55-75 A	90	70 sec	70 %	0.6 kg/h
3.2 x 350.0 mm	75-100 A	45	90 sec	70 %	0.9 kg/h
4.0 x 350.0 mm	85-160 A	30	70 sec	70 %	1.8 kg/h