

Masterweld NiFeCi Structural Electrode for Cast Iron

■ **Description & Applications :**

High strength nickel iron machinable electrode for joining and building up on cast irons. Low amperage, smooth arc, minimum spatter and high resistance to cracking. Due to Bi-metallic core wire this product gives excellent current carrying capacity which will prevent overheating. For the repair of grey, S.G., nodular or ductile irons where higher strength is required, also suitable for the joining of cast iron to mild steel.

■ **Related Specification:**

AWS A5.15 E Ni-Fe-Ci
EN 1071 E C Ni-Fe-Ci-I

■ **Typical All Weld Metal Chemical Analysis %:**

Ni	Fe
55.0	45.0

■ **Typical All Weld Metal Mechanical Properties:**

As Welded

Ultimate Tensile Strength	448 N/mm ²
Elongation	20%
Hardness	180 Brinell

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

2.5mm	3.2mm	4.0mm	5.0mm
40-70	70-110	110-150	130-170

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 150°C before use.

Manufactured under an ISO 9001 registered quality management system.

