



# Selectarc Fe-Ni/Cu

*Ferro Nickel Electrode  
Core Wire Copper Coated*

## Classification

AWS A 5.15 : ENiFe-CI  
ISO 1071 : E C NiFe-1 3

DIN 8573 : E NiFe-1 BG 13

## Description & Applications

Graphite-basic coating with a copper coated core wire and a Ferro-Nickel alloy deposit (55%Ni - 45%Fe) for welding and repairing of nodular cast iron. Particularly recommended for steels/cast iron or pipe to flange welding in cast iron. Good wash-in and flow of the weld metal. Principal advantage of this electrode : exceptional resistance against overheating during welding due to the copper plated core wire. Exceptional welding characteristics.

**Main application:** For foundry defects, repairing of engine blocks, frame of tool machines, gearboxes, reducing pieces, pump bodies, valve bodies.

### Base materials

**Grey cast iron, malleable and nodular cast iron :**

ASTM	DIN	NFA
A48 class 25B to 60B	GG-15 to GG-40	FGL 150 to FGL 400
A536 Grade 60-80	GGG-40 to GGG-60	FGS 400-12 to FGS 600-3
	GTS-35 to GTS-65	MN350-10 to MN650-3

## Typical Weld Metal Composition ( % )

C	Si	Mn	Ni	Cu	Fe
1.1	1.2	0.8	53.0	4.0	Rem.

## All Weld Metal Mechanical Properties

R <sub>m</sub> ( MPa )	Hardness
>400	Approx. 200 HB

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x350	3,2x350	4,0x350
Current	( A )	70	100	150

Weld on clean and exempt from grease surfaces (previous grinding of the joint). Reduce the heat input to a minimum, weld with the lowest practical amperage, keep temperature low ( < 100°C ) in order to reduce the risk of cracks in the base metal, depose short beads of about 6 cm and peen immediately. Reignite on the weld metal –not on the casting.

ind.12



= + ~ 40 V

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