



## SELECTARC Fonte Fe2

Special Ni - free  
Cast Iron Electrode

### Classification

AWS A 5.15 : ESt  
ISO 1071 : E C Fe - 2 3

DIN 8573 : E Fe - 2 B 24

### Characteristics

Special basic coated "Nickel - Free" electrode for cold welding of cast iron with a colour matching deposit, stable arc, good bonding and flow of the weld metal.

### Applications

To repair defects in foundries, for welding of Cast iron, as first layer before surfacing of cast iron. Welding of Grey cast iron, Malleable and Nodular cast iron.

#### Base materials

ASTM	DIN	NFA
A 48 class 25B - 60B	GG-15 to GG-40	FGL 150 to FGL 400
A536 Grade 60	GGG - 40 to GGG - 70	FGS 400 -12 to FGS 700-3
	GTS - 35 to GTS - 65	MN350-10 to MN650 - 3

### Typical Weld Metal Composition (%)

C	Si	Mn	V	S	Fe
0.05	0.50	0.40	10.00	0.02	base

### All Weld Metal Mechanical Properties (Typical)

Conditions	Hardness (HB)
	AW
AW	250

### Welding Current & Instructions

Electrode	ØxL (mm)	2.5 x 350	3.2 x 350	4.0 x 350
Current	(A)	70 - 80	100 - 120	130 - 150

Clean the weld area and free from grease (previous grinding of the joint). Apply a heat input as low as possible and keep the temperature low in order to reduce the risk of producing cracks in the base metal. Weld with lowest practical current and deposit short and narrow beads. To reduce internal stresses, hammering of the beads is recommended after each pass (essential on rigid pieces). Maintain Interpass temperature : < 100°C.



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

= +,- ~ 40 V

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