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Fonte NiFe260

Ferro Nickel Electrode

FSH WELDING GROUP
INNOVATIVE WELDING CONSUMABLES
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Classification

AWS A 5.15 : ENiFe-CI DIN 8573 : E NiFe-1 BG 13
ISO 1071 : ENiFe

Description & Applications

Graphite basic coated electrode with a Ferro-Nickel alloy deposit for joining and repairing nodular cast iron. Deposit homogeneous and highly resistant against cracks. Particularly recommended for dissimilar welding of cast iron to steels and cast iron constructions.
Good bonding and flow of the weld metal.
Main applications : Tube to flange welding. Welding of defects in foundries, repairing of engine blocks, houses of tool machines, gearboxes, reducing parts, pump bodies, cast pieces, 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	Fe
0.6	0.6	0.8	56	base

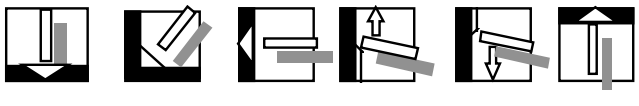
All Weld Metal Mechanical Properties

R_m (MPa)	Hardness
>320	approx. 190 HB

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350	5,0x350
Current	(A)	80	110	150	180

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 the temperature low (< 70°C) in order to reduce the risk of cracks in the base metal. Reignite on the weld metal.
For repair welding of lamellar cast iron, depose short beads of about 6 cm and peen immediately.



1G/PA 2F/PB 2G/PC 3G/PF 3G/PG 4G/PE

= +	~ 40 V

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