

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.

Классификации	AWS A5.15 : ENiFe-CI-A EN ISO 1071 : E C NiFe-CI-A 1
----------------------	---

Сварочный ток	AC, DC+-
Тип сплава	Ni-Fe alloy
Тип покрытия	Basic Special high graphite

Хим. состав наплавленного металла

C	Mn	Si	S	P	Ni	Al	Fe
1.5	0.8	0.7	0.003	0.006	51	1.4	46

Данные наплавки

Диаметр	Ток	Кол-во электродов/кг наплавл. Металла	Fusion time per electrode at 90% I max	КПД, %	Производительность наплавки при токе 90% от максимального
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