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 electrode type of pure nickel 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.

Specifications	
Classifications	SFA/AWS A5.15 : ENiFe-CI-A EN ISO 1071 : E C NiFe-CI-A 1
Approvals	CE : EN 13479 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+-
Alloy Type	Ni-Fe alloy
Coating Type	Basic Special high graphite
Min AC OCV	50

Typical Weld Metal Analysis %					
C	**Mn**	**Si**	**Ni**	**Al**	**Fe**
1.5	0.8	0.7	51	1.4	46

Deposition Data				
Diameter	**Current**	**Deposition Efficiency (%)**	**Burn-off Time/Electrode**	**Deposition Rate @ 90% I max**
2.5 x 300 mm (0.098 x 11.8 in.)	55-75 A	70 %	70 sec	0.6 kg/h (1.3 lbs/h)
3.2 x 350 mm (1/8 x 13.8 in.)	75-100 A	70 %	90 sec	0.9 kg/h (2.0 lbs/h)
4.0 x 350 mm (5/32 x 13.8 in.)	85-160 A	70 %	70 sec	1.8 kg/h (4.0 lbs/h)