

## OK NiFe-CI

A nickel-iron electrode for welding normal grades of cast iron and for joining them to steel. Can be used for malleable nodular cast iron and alloy cast iron. It has a special iron jacketed Ni core wire, which gives the electrode much improved current carrying capacity compared to electrodes with a homogeneous core wire. The electrode produces a weld metal stronger and more resistant to solidification cracking than the pure nickel electrode types. Typical applications are repair of pump bodies, heavy machine sections, gear teeth, flanges and pulleys.

### Specifications

<b>Classifications</b>	SFA/AWS A5.15 : ENiFe-CI EN ISO 1071 : E C NiFe-1 3
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<b>Welding Current</b>	AC, DC+
<b>Alloy Type</b>	Ni-Fe alloy
<b>Coating Type</b>	Basic Special high graphite

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength
ISO		
As Welded	380 MPa	560 MPa

### Typical Weld Metal Analysis %

C	Mn	Si	Ni	Al	Cu	Fe
0.9	0.6	0.5	53	0.4	0.9	44

### Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300.0 mm	60-100 A	22 V	70 %	45 sec	0.8 kg/h
3.2 x 350.0 mm	80-150 A	23 V	70 %	56 sec	1.2 kg/h
4.0 x 350.0 mm	100-200 A	23 V	70 %	59 sec	1.6 kg/h