

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.

Tekniset tiedot	
Luokitukset	SFA/AWS A5.15 : ENiFe-CI-A EN ISO 1071 : E C NiFe-CI-A 1
Hyväksynnot	CE : EN 13479 UKCA : EN 13479

Hyväksynnot perustuvat tehtaan sijaintiin. Ota yhteyttä ESAB:iin saadaksesi lisätietoja.

Hitsausvirta	AC, DC+-
Seostyyppi	Ni-Fe alloy
Päällystetyyppi	Basic Special high graphite

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

Hitsausarvot				
Halkaisija	A	Hyötyluku (%)	Puikon palo aika 90% maksivirralla	Sulatusnopeus 90 % I max
2.5 x 300.0 mm	55-75 A	70 %	70 sec	0.6 kg/h
3.2 x 350.0 mm	75-100 A	70 %	90 sec	0.9 kg/h
4.0 x 350.0 mm	85-160 A	70 %	70 sec	1.8 kg/h