

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.

Specifiche	
Classificazioni	SFA/AWS A5.15 : ENiFe-CI-A EN ISO 1071 : E C NiFe-CI-A 1
Omologazioni	CE : EN 13479 UKCA : EN 13479

Le approvazioni si basano sulla posizione della fabbrica. Si prega di contattare ESAB per ulteriori informazioni.

Corrente di saldatura	AC, DC+-
Tipo di lega	Ni-Fe alloy
Tipo di rivestimento	Basic Special high graphite

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

Dati deposito				
Diametro	Amp	Efficienza (%)	Tempo di fusione per elettrodo al 90% I max	Tasso di deposito al 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