

Graphite-basic coated electrode with a high nickel concentration percentage, designed for cast iron repairs. It has excellent mechanical properties and is highly resistant to cracks. It is recommended for cast iron/steel & dissimilar assemblies.

Classification

EN ISO 1071 : EC NiFe-CI
AWS A 5.15 : E Ni Fe CI 3
DIN 8573 : E NiFe 1 BG 13

Applications

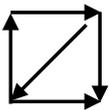
Welding and reinforcing cast iron, cast iron, modular cast iron and cast iron steel assemblies:

- Crankcase,
- Cylinder head,
- Engine block,
- Pump casing,
- Gear wheel.

Benefits

- Homogeneous ferronickel alloy, very resistant to cracks.
- Excellent performance on old cast iron.
- High mechanical specifications.

Positions and polarity



- Ignition from 40V - Direct current.
- **Electrode polarity (+).**

Chemical properties

C %	Mn %	Si %	Ni %	Fe %
1.00	< 1.00	< 2.00	56.00	base

Mechanical properties

Re	Rm
390	550

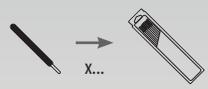
Recommendations

Ø electrode (mm)	2.5	3.2
thickness (mm)	3 ▶ 6	3 ▶ +
welding current (A)	70	100

- Welding in small cords,
- Hammer during cooling.



Packaging

Ref.	Ø (mm)	length (mm)	
083332	Ø 2.5	350	12
083349	Ø 3.2	350	9
081956	Ø 3.2	350	156