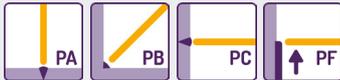


Processing information

Re-drying: 100 - 150 °C/1 h
(if required)

Welding positions:



Polarity:



Clean welding area carefully and remove cast skin from base material. Low heat input during welding is required. Therefore weld bead width should not be more than twice of electrode diameter, length max. 10 times. For reducing the tension the weld should be hammered just after welding. The FICAST NIFE needs DC +polarity to have a low heat input especially with sensitive castings.

Application

Nickel-iron electrode for cold-welding of grey cast iron with lamellar and globular graphite structure and malleable iron. It can also be used for joints of cast iron (GGL and GGG types) with unalloyed steel. The welding with this electrode produces a higher strength compared to Ficast Ni. The alloyed weld metal is mainly produced by the core wire which contains 60 % nickel and 40 % iron. The weld metal is easily machinable and highly crack-resistant. It is very similar to the base metal in colour and corrodes later than the base metal. This soft-welding electrode has good wetting abilities.

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Fe	Ni
1,3	≈ 40	B

Tensile Strength Rm [MPa] > 450

Hardness [HB] ≈ 160

Field



Characteristic
basic-graphitic-coated,
NiFe core wire

Standards
ISO 1071
E C Ni Fe-CI3
AWS A 5.15
E NiFe-CI

Approvals



Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.003.250	2,50/300	80 - 110	1,3	82	15,9
00.003.323	3,25/350	100 - 140	1,5	47	31,9
00.003.403	4,00/350	130 - 170	1,5	32	46,9



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