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Comparable specifications

ASME SFA A 5.15: ENiFe-CI
EN ISO 1071: SC NiFe-1
Werkstoff Nr.: ~ 2.4560

Description and applications*

* *Illustrative, not-exhaustive list*

Ferro-nickel solid wire for welding of cast iron and joining cast iron with steel. Excellent weldability with extreme crack resistance with a ductile weld deposit. Good welding and wetting characteristics and high resistance against porosity.

This grade may be mainly used for:
repair welds on, as well as joining, work pieces of cast iron, including nodular iron;
welding work pieces of cast iron to steel and some nonferrous base metals;
dissimilar welding between cast iron and high alloyed stainless and heat resistant steels or mild steels;
applications such as rebuilding shafts, wheels, critical joints between steel and cast iron, etc.

Recommended for welding castings containing phosphorus levels higher than normal. Experience has shown that satisfactory welds can be made on thick and highly restrained weldments, and on high-strength and engineering grades of cast iron.

Weldable base materials*

* *Illustrative, not-exhaustive list*

Grey cast iron, malleable, nodular.

All-weld metal mech. properties*

* *For reference only values*

Tensile strength (Rm): 400 - 579 N/mm²

Chemical composition*

* *For reference only values*

C	Mn	Si	P	S	Fe	Ni	Cu	Al
max	max	max	max	max	rem.	59.00	max	max
2.00	0.80	0.20	0.03	0.03		62.00	2.50	1.00

Standard packaging data*

Welding process	Product type	Ø mm (inches)	Packing type	Weight kg (lbs)	Length mm (inches)
GMAW **	filler wire	0.80 - 1.20 (0.030 - 0.047)	spools BS300 / D300	15 (33)	n.a.
GTAW **	filler rod	1.60 - 4.00 (1/16 - 5/32)	cardboard boxes / tubes	5 (11)	1000 (39.4)
SMAW **	core wire for electrodes	1.60 - 5.00 (1/16 - 0.197)	wooden boxes	500 - 750 (1100 - 1650)	250 - 450 (10 - 18)

* *Other sizes and packing types are available upon request*

** *GMAW: gas metal arc welding; GTAW: gas tungsten arc welding; SMAW: shielded metal arc welding*

Marking

Each filler rod for GTAW welding is durably marked with an identification traceable to the unique product type. Welding filler materials wound on spools or in coils are durably marked on the coil or spool with an identification traceable to the unique product type.

The outside of each unit package is suitably labelled with at minimum the following data: grade, diameter, heat, lot no., classifications.

Customized labels are available upon request.

Lot classification

All our productions fulfil the **Class S3** requirements acc. to EN ISO 14344.