

NiFe 2

CATEGORY SMAW Stick Electrodes

TYPE Special "bimetal" core wire coated electrode for welding cast iron with high tensile strength.

APPLICATIONS NiFe 2 is suitable for welding grey and malleable cast iron, equally suitable for SG iron. Use this type in case a high tensile strength is required or because of his non overheating coating. Also suitable for joining steel to cast iron !

PROPERTIES NiFe 2 has a few benefits compare to other "FeNi" types because of improvements, such as: weldable with very low current, non overheating coating and a powerful arc at very low amps. The deposit is free from porosity even on old and or otherwise diluted base material. Preheating is normally done to slow down the cooling speed, in case you can not control the cooling speed it is better to keep the work peace at a low temperature during welding and hammer immediately after welding.

CLASSIFICATION

AWS	A 5.15: E NiFe-C1
EN ISO	1071: E NiCu-1
DIN	1736: E NiFe-1-BG 23

SUITABLE FOR Spheroidal cast iron, deluted cast iron, old cast iron, steel to cast iron etc. EN 1561: EN-GJL-100 (GG10) till EN-GJL-350 (GG35), EN 1562: EN-GJMB-350 (GTS 35) till EN-GJMB-550 (GTS 55), EN- GJMW-350 (GTW 35) till EN- GJMW-550 (GTW 55), EN1563: EN-GJS-400 (GGG 40) till EN-GJS-700 (GGG 70).

APPROVALS CE approved

WELDING POSITIONS:



Fe	Mn	Si	Cr	Ni	Mo
42				54	

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW		380-480					190

AW: as welded

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters			Packing		
	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000	
2.5	350	60-80	2.50	15	16.1	
3.2	350	90-110	3.40	20.4	31.2	
4.0	350	130-170	3.00	18	47.0	
5.0	450	150-185			94.1	

REDRYING TEMPERATURE 180°C / 1hr.