ES NiFe-Cl

Type Basic special

SMAW

ENiFe-Cl

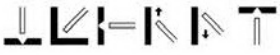
ESWECO
The Art of Welding

Description

An electrode of the nickel-iron type for welding normal grades of cast iron and for joining them to steel.
The electrode has very good current-carrying capacity. The electrode produces a weld metal that is stronger and more resistant to solidification cracking than that of the nickel electrode type.
ES NiFe-Cl is especially suited for welding heavy sections such as motor blocks, housings, machine parts, frames, defective castings and building-up worn sections. Weld deposits are machinable and the deposit color will approximate that of cast iron.

Current

AC, DC+ OCV 50 V



Classifications

SFA/AWS A5.15	ENiFe-Cl
EN ISO 1071	E C NiFe-1 3

Typical all weld metal composition, %

C	Si	Mn	Ni	Cu	Al	Fe	Nb
0.9	<0.8	0.7	52	1.0	0.3	44.0	0.2

Typical mech. Properties all weld metal

Yield stress, MPa	380
Tensile strength, MPa	560
Elongation, A5 %	>15
Hardness:	200 HB

Welding parameters

Diameter,mm	Length,mm	Welding current, A	Arc voltage,V
2.5	350	45-80	21
3.2	350	60-110	23
4.0	350	90-120	24