

Superfonte NiFe deposits a nickel-iron alloy of relatively high strength and ductility, particularly suitable for all kinds of cast iron, including those with a high phosphorus content. The deposited weld metal is machinable and resistant to cracking. The slag is easily detachable. Suitable for welding mild steel to all grades of cast iron. Ideal for repairs to production castings and damaged castings Particularly suitable for ordinary grey irons, spheroidal cast irons, type "Ductile", "Meehanite", etc. Efficiency 100%.

Classification

AWS A 5.15: E NiFe Cl

Approvals

Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
1-2	0.50	0.80	≤ 0.030	≤ 0.030	-	Rem	-	-	43	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	≥ 296	400-579	≥ 6	-	≥ 165 HB

Materials

GJS-350 to GJS-700;GJMW -350-4 to GJMW-360-12;GJMB-300 to GJMB-700

Storage and redrying

Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 80 °C for 1 hour, once only.

Current condition and welding position

DC+; AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	30-80	19,1	11,5
3,2	350	50-100	31,0	18,6
4,0	350	80-130	45,7	27,4