

SUNWELD FENI

Cast Iron Electrode



CLASSIFICATION

AWS/A 5.1 : E Ni Fe Cl

CHARACTERISTICS

A Nickel iron core wire electrode specially designed for producing high strength joints in malleable cast iron and in nodular cast iron. The weld metal has good ductility and machinability. Slag is very thin and run to the sides of weld bead.

APPLICATIONS

Welding of all types of cast iron, joining of cast iron to steel, filling up deep cavities in casting, can be used on high Sulphur/Phosphorous castings.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Silicon	Nickel	Iron
0.98	0.67	55.80	Balance

HARDNESS (Typical) : 220 BHN Max

CURRENT RANGE & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
2.50	350	50-70	2 Kg	10 Kg
3.15	350	70-100	2 Kg	10 Kg
4.00	350	100-130	2 Kg	10 Kg
5.00	350	130-170	2 Kg	10 Kg

RECOMMENDATIONS:

Use low currents smallest possible size of electrode and lay small beads to avoid overheating. Peen the weld bead to reduce welding stresses. Cool the welded piece slowly under insulation. For the best results pre heat the job up to 300°C.