



Classification : DINENISO 1071

E CNife-1 1

AWSA5.15

E Nife-CI

Homologations : Consign DVS 1502, T1

Applications types & characteristics :

Special-coated, bimetallic-soul graphite-to-ferro-nickel-soul electrode, which allows for very rapid fusion by direct current and alternating current without any risk of overheating. Suitable for welding all types of grey cast iron and also for welding cast iron with steel, but especially nodular cast iron. The colour of the deposit is very similar to that of the base metal, and the corrosion will be identical to that of the base metal later. This electrode excels because of a very high resistance to cracking and a high resistance to the traction of the welding metal. Even in refined areas, the cord is still usable.

Set up for welding :

Clean the surface of the room thoroughly, making sure it is completely degreased (following a previous correction). When welding the melting, the heat intake should be as low as possible (low amperage). The cord must not exceed twice the diameter of the wire to soul and in length ten times the diameter of the wire to soul. To limit the internal stress of the base metal, it is advisable to hammer the cords after each pass.

In some cases, it is advisable to preheat to 300oC followed by a slow cooling.

ISARC Fonte Nife will need to be welded to the positive of the direct current when a calm welding metal flow and good penetration are essential. Alternating current welding offers the highest resistance to cracks. The constant change in polarity favours a smooth, flat cord that is important for hard-to-weld cast iron parts.

Special tip: The bimetallic core gives a very good resistance to overheating and a high performance to fusion. This allows the electrode to melt down its entire length.

Traction to resistance Rm N/mm ²	Elastic limitations Rp0,2 N/mm ²	Elongation A ₅ %	Choc resistance ISO-VJ at -20°C
500	350	18	env. 190

Welded metal analyse in % : (% of weight)

C	Si	Mn	Ni	Fe
1,1	1,2	0,75	54	42

Electrical current : = +/-, ~ / 50 V

Welding passes : PA, PB, PC, PD, PE, PF, PG

Post-drying : 1 h, 120°C +/- 10°C (if necessary)

Diam/Long	Ampere (A)	Unit/package	Unit/box	kg/1000	kg/packaging	kg/box
2,5 x 300	60 - 80	314	1258	15,9	5,0	20,0
3,2 x 350	70 - 100	160	639	31,3	5,0	20,0
4,0 x 350	95 - 130	105	422	47,4	5,0	20,0

Responsibility: The purpose of this document is to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for the applications for which it is intended. We reserve the right to modify the characteristics of its products without notice. Descriptions, illustrations and features are provided as an indication and cannot be the responsibility of our company. Smoke: View information on the Security Data Sheet available on request