

# FERRICAST

## CLASSIFICATIONS

**AWS A/SFA 5.15** ENi Fe-CI  
**IS 5511** E Ni Fe G16

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

An electrode with Ferro Nickel core wire specially designed for welding cast iron the cold way. The nickel-iron weld deposit does not pick up carbon from the base metal and hence remains ductile, soft and easily machinable, at the same time retaining adequate strength. This permits successful use of the electrode without the necessity of preheating even on large complicated castings.

## TYPICAL APPLICATIONS

Easy and intimate fusion with all grade of cast iron the electrode is best suited for welding and repairing all cast iron components. Successful applications include repair of broken castings, building up of worn surfaces or correcting machining errors on castings and joining cast iron to steel. Welding of nodular graphite iron, malleable iron subject to heavy wear

## CURRENT CONDITIONS: AC, DC

4.0	3.2	2.5
90-120	70-110	40-70

## WELDING POSITIONS

F & H Fillet

## REDRYING CONDITIONS

150°C for 1 hour  
(Optionally also available in vacuum-packed condition.)

### WELD METAL CHEMISTRY, (%)

C - 2.0 max.	Cu - 2.5 max.	S - 0.03 max.
Mn - 1.0-2.5	Ni - 45.0-60.0	Fe- Rem.
Al - 1.0 max.	Si - 4.0 max.	

### PACKING DATA

Dia., mm	4.0	3.2	2.5
Length, mm	300	300	300
Wt. per carton, kg	1	1	1
Cartons / box	10	10	10
Net wt per box, kg	10	10	10

### MECHANICAL PROPERTIES - ALL - WELD

Condition	Hardness
As-welded	BHN 150-190



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