

Processing information

Re-drying: 100 - 150 °C/1 h
(if required)

Welding positions:



Polarity:



Clean welding area carefully and remove cast skin from base material. Low heat input during welding is required. Therefore weld bead width should not be more than twice of electrode diameter, length max. 10 times. For reducing the tension the weld should be hammered just after welding. The FICAST NIFE B needs DC +polarity to have a low heat input especially with sensitive castings.

Application

Nickel-iron electrode for cold welding of grey cast iron with lamellar and globular graphite structure and malleable iron; also suited for joints of cast iron (GGL and GGG types) with unalloyed steel materials; high ampacity, stable arc and good wetting abilities due to bi-metallic core wire. A higher strength can be achieved compared to welding with FICAST NI. The weld metal is machinable and highly crack-resistant.

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Fe	Ni
1,3	≈ 40	B

Tensile Strength Rm [MPa] > 450

Hardness [HB] ≈ 165

Field



Characteristic
**basic-graphitic-coated,
NiFe bimetal core wire**

Standards

ISO 1071
E C Ni Fe-CI3
AWS A 5.15
E NiFe-CI

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.004.250	2,50/300	70 - 100	1,3	82	15,9
00.004.323	3,25/350	100 - 130	1,5	47	31,9
00.004.403	4,00/350	120 - 160	1,5	32	46,9



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