# Kjellberg **FINSTERWALDE**

### STICK ELECTRODES, CAST IRON

### FICAST NIFE B

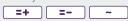
### **Processing informatione**

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 [%]

1.3 ≈ 40

Tensile Strength Rm [MPa]

Hardness [HB] ≈ 165

> 450

## **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

Field







Characteristic

basic-graphiticcoated. NiFe bimetal core wire

> **Standards** ISO 1071 E C Ni Fe-Cl3 **AWS A 5.15** E NiFe-Cl



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