Kjellberg® FINSTERWALDE

STICK ELECTRODES, CAST IRON

FICAST NIFE BAL

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 FICASTNIFE BAL needs DC+polarity to have a low heat input especially with sensitive castings.

Application

Special electrode for cold-welding of grey cast iron with lamellar and globular graphite structure and malleable iron, also suited for compounds of cast iron (GGL and GGG types) with unalloyed steels. The higher Al content effects improved welding properties while achieving a higher resistance to porosity but reduced toughness compared to FICAST NiFe and FICAST NiFe B. The bimetal centre wire ensures a stable arc, good wetting properties and a higher deposition rate due to the high current carrying capacity.
The weld metal can be mechanically processed and is characterized by a high cracking resistance.

All Weld Metal Mechanical Properties						
Weld Metal Composition [%]						
C	Si	Mn	Fe	Ni	other	
1,3	0,7	0,7	47	50	Al	
Tensile Strength RmN/mm²						> 450
Hardness [HB]						180

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.007.323	3,25/350	90 - 110	1,5	47	31,9
00.007.403	4,00/350	110 - 150	1,5	31	48,4

Field

Characteristic

basic-graphitic-coated, NiFe bimetallic core wire

Standards

ISO 1071
E C Ni Fe-Cl A1

AWS A 5.15
E NiFe-Cl-A

THE ORIGINAL MADE IN GERMANY SINCE 1921

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