



Nexus NiFe

Ni Fe – Electrode for MMA welding of Cast Iron

Graphite based, Barium free, Nickel Iron Electrode for repair and maintenance of nodular iron and for joining some non-ferrous based metals. Cast Iron containing Phosphorus levels high than normal 0.20% are better welded using NiFe than Ni electrode for maximum strength.

International Standards

EN ISO 1071:2003	AWS A5.15- 90
E C NiFe-CI	E NiFe-CI

Typical All-Weld Metal Analysis (wt%)

C	Si	Mn	Ni	Fe
1.0	<2.0	<1.0	56.0	Balance

Typical All-Weld Metal Mechanical Properties

Tensile Strength N/mm ²	Hardness HB
>400	200

Welding Positions

All positions, except vertical down

Materials

Grey, nodular SG, malleable and high strength cast irons,

Packaging

Size mm	2.5 x 350	3.2 x 350	4.0 x 350
Pieces/Package	125	80	60
Kg/Package	2.5	2.5	2.5

Operating Requirements

DC+ AC (40ocv min)	70 A	100 A	145 A
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Notes

Ensure the removal of all defects, machine or grind to sound metal. Weld using a preheat of 300⁰C and ensure the whole casting is soaked at this temperature prior to welding and maintain throughout the process. Post weld the casting should be cooled very slowly and evenly.

For welding without preheat the temperature during welding should not exceed 100⁰C (hand hot), deposit small welds at low currents without weaving. Cooling should be slow and even throughout.