

FeNi 60 N

CATEGORY SMAW Stick Electrodes

TYPE Special coated electrode for welding cast iron with high tensile strength.

APPLICATIONS FeNi 60 N is suitable for welding grey and malleable cast iron, equally suitable for SG iron. Use this type in case a high tensile strength is required or because of his non conductive coating to weld in difficult welding positions where coating contact is unavoidable with the base metal.

PROPERTIES FeNi 60 N has a few benefits compare to other "FeNi" types because of improvements, such as: weldable with very low current, non conductive coating and a powerful arc at very low amps. Preheating is normally done to slow down the cooling speed, in case you can not control the cooling speed it is better to keep the work peace at a low temperature during welding and hammer immediately after welding.

CLASSIFICATION

AWS	A 5.15: E NiFe-C1
EN ISO	1071: EC NiCu-1
DIN	1736: E NiFe-1-BG 23

SUITABLE FOR Spheroidal cast iron, deluted cast iron, old cast iron, steel to cast iron etc. EN 1561: EN-GJL-100 (GG10) till EN-GJL-350 (GG35), EN 1562: EN-GJMB-350 (GTS 35) till EN-GJMB-550 (GTS 55), EN- GJMW-350 (GTW 35) till EN- GJMW-550 (GTW 55), EN1563: EN-GJS-400 (GGG 40) till EN-GJS-700 (GGG 70).

APPROVALS CE approved

WELDING POSITIONS:



Fe	Mn	Si	Cr	Ni	Mo
43				53	

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW		380-480					200

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters			Packing		
	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000	
2.5	350	70-100	3	18	16	
3.2	350	100-130	3.5	21	31.2	
4.0	350	130-150	3.2	19.2	47.0	
5.0	450	150-170			94.1	

REDRYING TEMPERATURE 200°C / 1hr.