

## NiFe 2

**CATEGORY** SMAW Stick Electrodes

**TYPE** Special "bimetal" core wire coated electrode for welding cast iron with high tensile strength.

**APPLICATIONS** NiFe 2 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 overheating coating. Also suitable for joining steel to cast iron !

**PROPERTIES** NiFe 2 has a few benefits compare to other "FeNi" types because of improvements, such as: weldable with very low current, non overheating coating and a powerful arc at very low amps. The deposit is free from porosity even on old and or otherwise diluted base material.  
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: E 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
42				54	

### MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0.2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW		380-480					190

AW: as welded

### WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
2.5	350	60-80	2.50	15	16.1
3.2	350	90-110	3.40	20.4	31.2
4.0	350	130-170	3.00	18	47.0
5.0	450	150-185			94.1

**REDRYING TEMPERATURE** 180°C / 1hr.