

NiFe 60/40 K

CATEGORY SMAW Stick Electrodes

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

APPLICATIONS NiFe 60/40 K 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 and due to the special coating to weld in difficult welding positions.

PROPERTIES NiFe 60/40 K has a few benefits compare to other "FeNi" types because of improvements, such as: weldable with very low current, copper coated core wire 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 11

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:



WELD DEPOSIT WEIGHT % (TYPICAL)

C	Si	Mn	Ni	Fe	Cu
1.1	1.2	1.1	54	43	0.6

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	350	500	10				190

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) AC/DC-/+	kg / can	kg / 6pack	kg / 1000
2.5	350	60-80	3	18	15.9
3.2	350	70-100	3.4	20.4	31.3
4.0	350	95-130	3.2	19.2	47.4
5.0	450	140-160			95.2

REDRYING TEMPERATURE 120°C / 1hr.