Stanvac INTERNATIONAL

Product Data Sheet

STAVINOX NIFE

Ferro Nickel Electrode

Classification: AWS A5.15: ENiFe-CI **DIN 8573:** E NiFe-1- BG 11

Description and applications: Graphite basic coated electrode with a Ferro-Nickel alloy deposit for joining and repairing nodular cast iron. Deposit is homogeneous and highly resistant against cracks. Particularly recommended for dissimilar welding of cast iron to steel and fabrication of cast iron. Weld metal has sound fusion and good fluidity during welding. Typically used to repair of foundries, engine blocks, houses of tool machines, gearboxes, reducing parts, pump bodies, cast pieces, valve bodies etc...

Base materials: Grey cast iron, malleable and nodular cast iron:

ASTM: A48 class 25B to 60B, A536 Grade 60-80

DIN: GG-15 to GG-40, GGG-40 to GGG-60, GTS-35 to GTS-65

NFA: FLG 150 to FLG 400, FGS 400-12 to FGS 600-3, MN350-10 to MN650-3

All weld metal Mechanical Properties

Hardness (BHN), 2nd layer (as welded)
150 - 170

Typical weld metal composition (%)

Nickel wt. %	Fe & Others
50	BALANCE

Welding current (A) range

2.50 mm	3.15 mm	4.00 mm
50 - 70	70 - 90	100 - 140

Welding recommendations: Always use AC or DC current, Welding area must be cleaned very carefully and cast skin should be removed accordingly. Low heat input is required. Therefore, weld bead width should be max. twice of electrode diameter, length max. 10 times. For reducing the tension, the weld should be hammered just after welding.

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