

PRODUCT INFORMATION

SIFTRODE CAST NIFE

EN ISO 1071-A E C NiFe-CI
 AWS A5.15 E NiFe-CI
 DIN 8573 E NiFe BG1

DESCRIPTION

Cast iron electrode with NiFe bimetal core wire. Dedicated for cold welding grey, nodular and malleable cast iron and for joining cast iron with steel. Excellent welding properties, does not overheat, the speed of welding is high, almost no spatters, slag removes easily. Can be welded with AC Uo < 50V and DC (+) and (-).

WELDING POSITIONS



Welding Current: AC, DC+
 Suitable positions: PA, PB, PC, PE, PF, PG

TYPICAL WELD METAL COMPOSITION

Ni	54.0 %
Fe	42.0 %

TYPICAL MECHANICAL PROPERTIES

Ult Tensile Strength	≥ 450 N/mm ²
Redrying	180° / 1h
Hardness	160-190 [HB]

MATERIAL TO BE WELDED

Grey cast, malleable cast iron, nodular cast iron

AVAILABLE FORMATS

ELECTRODE RODS (MMA / SMAW)			
Dia	1.0kg Pkt		Approx Pcs/KG
2.5mm	RE4002501		
3.2mm	RE4003201		
4.0mm	RE4004001		

CURRENT RANGE	
Dia (mm)	Amps
2.5	60-80
3.2	80-110
4.0	110-150

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email service@wholeweld.co.uk

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