



SUPERCAS^T Ni/Fe



- ▶ Nickel -Iron Core Wire/Basic, Graphite Coating
- ▶ Machineable Nickel-Iron Deposit for the Higher Strength Welding of Cast Irons, Particularly SG Irons

Identification

Coating - Black

End Tip - Green

Classifications

AWS A5.15 ENiFe-CI

Description & Applications

SUPERCAS^T Ni/Fe is a basic, graphite coated AC/DC electrode for the higher strength welding of cast irons. It is characterised by a soft, smooth arc with low penetration and spatter levels on both AC and DC power sources. Ease of striking is a feature of Supercast Ni/Fe.

This electrode is made from a Nickel-Iron core wire and produces a ductile, machineable weld deposit with the extra strength required for welding SG (Spheroidal Graphite) irons. Supercast Ni/Fe may also be used for the repair and reclamation of all standard grades of grey cast iron, malleable iron, austenitic cast iron and some grades of meehanite cast iron. It is ideally suited to the dissimilar welding of these irons to steels.

Operational Data

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE * (amps)	ARC VOLTAGE RANGE (volts)**
3.2	350	50 - 100	23
4.0	350	80 - 130	26

*Recommended for DC+ or AC (minimum 45 0CV) operation

** Voltage is determined by arc current and electrode arc length. Arc voltage shown are typical and are only to be used as a guide.

#Note: 3G and 4G recommended for 3.2mm size electrodes.

Typical All Weld Metal Chemical Analysis

Mn	Ni	S	Fe
0.85	57.8	0.007	Bal

Typical All Weld Metal Mechanical Properties

Yield Stress	300 Mpa
Tensile Strength	500 Mpa
Deposit Hardness	200 - 220 HV (30)

Packaging Data

ELECTRODE SIZE (mm)	PACKAGING (KG)			APPROX NO OF RODS PER KG	PART NUMBER
	Packet	Carton	Mini Pack		
2.5	2.5	15	0.5	39	SNIFE32

Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.*

*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.