PRODUCT DATA SHEET
CAST IRON ELECTRODES

Supercast Ni/Fe

SUMMARY

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

IDENTIFICATION

Coating - Black  Tip - Green  Imprint - WIA SC NiFe

CLASSIFICATION

- AWS A5.15: ENiFe-Cl

DESCRIPTION AND APPLICATION

Supercast 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 mechanite cast iron. It is ideally suited to the dissimilar welding of these irons to steels.

OPERATIONAL DATA

<table>
<thead>
<tr>
<th>ELECTRODE SIZE (MM)</th>
<th>ELECTRODE LENGTH (MM)</th>
<th>WELDING CURRENT RANGE *(A)</th>
<th>ARC VOLTAGE RANGE **(V)</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.2</td>
<td>350</td>
<td>50 - 100</td>
<td>23</td>
</tr>
</tbody>
</table>

*Recommended for DC +/- or AC (minimum 45 OCV) operation.
**Voltage is determined by arc current and electrode arc length. Arc voltage shown is typical and is only to be used as a guide.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Ni</th>
<th>S</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.0</td>
<td>0.42</td>
<td>58.0</td>
<td>0.009</td>
<td>Bal</td>
</tr>
</tbody>
</table>

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

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

PACKAGING DATA

<table>
<thead>
<tr>
<th>ELECTRODE SIZE (MM)</th>
<th>PACKAGING (KG)</th>
<th>APPROX. NO. OF RODS PER KG</th>
<th>PART NO.</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.2</td>
<td>2.5</td>
<td>12.5</td>
<td>39</td>
</tr>
</tbody>
</table>

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Issue CA - December 2014