

EZ - Fe NIKALJ

CLASSIFICATION

EN ISO 1071	AWS / ASME SFA-5.15
E C NiFe-CI-1	ENiFe-CI

DESCRIPTION AND APPLICATION

A basic coated electrode for welding of grey cast iron, temper and steel cast without preheating. It is also suitable for welding of unalloyed, low-alloy and high-alloy steels, and for joining cast iron to steel. Weld deposit is machinable.

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

Hardness

HB

190

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

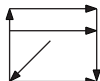
	Ni	Fe
%	55	45

RECOMMENDED WELDING CURRENT

Ø mm	2,5	3,2	4,0	5,0
A	60 - 80	90 - 110	120 - 140	150 - 170

PACKAGING

Electrode dimensions mm	Quantity per ton approx. pieces	Weight of packaging kg
Ø 2,5 x 300	62 500	1,3
Ø 3,2 x 350	32 500	1,3
Ø 4,0 x 350	21 800	1,5
Ø 5,0 x 450	11 000	6,0



Marking: EZ - Fe NIKALJ