

GRICAST NF



CLASSIFICATION : AWS/SFA 5.15 :E Ni-Fe-CI

CHARACTERISTICS :

An extruded, Nickel Iron electrode for cold welding of cast iron. Weldable in all positions . It has a soft and stable arc, having good striking and restriking properties. The weld metal including the heat effected zone is easily machinable. The crack resistance and toughness properties of weld metal are better than that of GRICAST-N or GRICAST-CN and also the weld deposit matches the colour of the parent metal better than GRICAST-N or GRICAST-CN.

TYPICAL APPLICATION :

Joining, repairing and surfacing of all types of weldable cast iron including Grey/Nodular and high phosphorous types without preheating of the parent metal.

WELDING INSTRUCTIONS :

For building up the part, the electrode should be connected to D.C. + polarity to reduce the transfer of heat to the work piece. To obtain flat bead the electrode is to be connected to D.C. polarity. By using A.C., the effect will be in between the aforementioned D.C. conditions, pre-heating of the parent metal is not necessary.

WELD METAL ANALYSIS (RANGE) % :

C	Mn	S	Si	P	Cu	Ni	Fe	Al
2.0 max	2.50 max	0.03 max	4.00 max	0.03 max	2.5 max	45.0-60.0	Remainder	1.0 max

MECHANICAL PROPERTIES (RANGE) :

Ultimate Tensile Strength Mpa	Yield Stress Mpa	Elongation (%) (L=4D)	Hardness (BHN)
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400-579

296-434

6-18

165-218

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS	PACKING PER BOX
2.50	350	40-80	2Kg×6=12Kg
3.15/3.20	350	70-120	2Kg×6=12Kg
4.00	350	90-140	2Kg×6=12Kg
5.00	350	110-170	2Kg×6=12Kg