

SUPERFONTE NiFe is a basic-graphite coated MMA electrodes with nickel-iron core wire, for joining and surfacing of cast iron without preheating or with a minimum of < 300°C, "cast iron cold welding". Higher weld metal strength than SUPERFONTE Ni. Used for welding applications on new cast-iron components made of globular gray-cast iron (GJS/GGG) and dissimilar joining of GJS to steel. Suitable for cast irons with globular graphite (GJS), black-heart cast iron (GJMB), white-heart cast iron (GJMW), austenitic cast iron and dissimilar joints to steel. Easy striking, stable arc, finely-rippled bead surface. Weld at low heat input with short beads, ~10 to 30 mm, and hammer peen. Weld metal can be machined.

Classification

EN ISO	1071 : E C NiFe-CI 1
AWS	A5.15: E NiFe-CI

Chemical analysis (Typical values in %)

C	Mn	Si	Ni	Fe
1.8	0.5	0.8	Rem	43

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Hardness
As Welded	≥ 280	400-580	≥ 6	150-170 HB

Materials

EN-GJMW-360

EN-GJS-350 bis EN-GJS-400 (GGG 40)

EN-GJMB-350 (GTS 35-10)

Storage

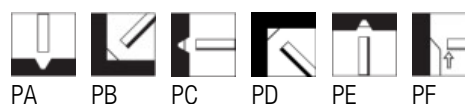
Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 80 °C for 1 hour, once only.

Current condition and welding position

AC; DC-; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		SMPA		VPMD	
				PC	Code	PC	Code	PC	Code
2.5	350	50-75	19.1	230	●	26	●	110	●
3.2	350	70-95	31.1	155	●	12	●	70	●
4.0	350	90-125	45.7	100	●			45	●