



GB/T 10044 EZNiFe-1
AWS A5.15 ENiFe-CI
EN ISO 1071 E C NiFe-1 3

AK ENiFe-CI

Description: A nickel-cored electrode designed to weld average grades cast irons .The weld metal is soft and easily machinable; deposition is performed on cold or slightly preheated material. It is suitable for joining cast irons to rectify casting and repair broken parts.

Application: Used to thin weld parts of cast irons and repair broken parts.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Fe	Al	Cu
Requirement	2.0	4.0	2.5	0.030	—	45-60	bal.	1.0	2.5
Actual Result	0.59	0.93	0.26	0.004	—	55.1	bal.	0.18	0.025

Recommended welding parameters:

Diameter/mm		2.5	3.2	4.0
Welding current/A	F/H	70- 110	100- 140	140- 180
	V/ OH	—	—	—