OK 92.58

SMAW

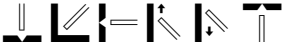
Type Basic Special high graphite ENiFe-CI-A

Description

A nickel-iron-cored electrode for joining normal grades of cast iron, such as grey, ductile and malleable irons. It is also suitable for the rectification and repair of these grades and for joining them to steel. Deposition is performed on cold or slightly preheated cast iron. The weld metal is stronger and more resistant to impurities than the nickel-cored type.

Welding current

AC, DC+ - OCV 50 V



Classifications

SFA/AWS A5.15	ENiFe-CI-A
EN ISO 1071	E C NiFe-CI-A 1

Typical all weld metal composition, %

C	Si	Mn	Ni	Al	Fe
1.5	0.7	0.8	51	1.4	46

Typical mech. properties all weld metal

Tensile strength, MPa	375
Hardness (HB):	180

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.5	300	55-75	21	0.70	90	0.6	70
3.2	350	75-100	23	0.70	45	0.9	90
4.0	350	85-160	24	0.70	30	1.8	70