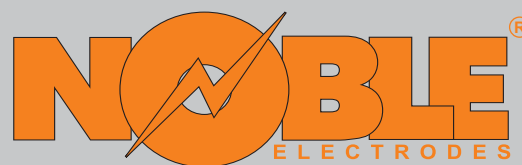


NOBLE - FeNi(55%)

Cast Iron Electrodes



CLASSIFICATION

AWS - A5.15: ENiFe-Ci

Characteristics : Noble - FeNi(55%) is a medium coated electrode with FeNi core wire. Suitable for welding cast iron. The nickel-iron weld deposit gives ductile, soft and easily machinable weld joint, at the same time retaining adequate strength.

Applications : Noble - FeNi(55%) is suitable for the welding of cast iron components, repair of broken castings, building up of worn surfaces or correcting machining errors on castings and joining a cast iron to steel. Welding of nodular graphite iron, malleable iron subject to heavy wear.

Mechanical Properties

Mechanical Tests	AWS Specifications
Yield Strength	296 – 434 N/mm ²
Tensile Strength	400 – 579 N/mm ²
Elongation	6 – 18 %
Hardness	165 – 218 (BHN)

Chemistry of Wire (%)

Elements	C	Mn	Si	S	Fe	Ni	Cu	Al
Range	2.0% Max	2.5 % Max	4.0% Max	0.03% Max	Balance	45- 60%	2.5% Max	1.0% Max

Packing Specifications & Current Condition

Size (mm)	Pkts. / Case	Wt. / Pkt.	Current (Amp.) AC (70 V), DC (+)
3.15 x 350	05	2 Kg.	70 - 110
4.00 x 350	05	2 Kg.	100 - 140

Preheating : Preheating of casting job before welding to 400° to 540° C is recommended for better results in terms of strength & weldability.

“Noble – Characterized by all Excellent Qualities”