



# PRODUCT DATA SHEET

## CAST IRON ELECTRODES

WCD 6129

### Supercast Ni/Fe



#### SUMMARY

- > Nickel-Iron Core Wire/Basic, Graphite Coating
- > Machineable Nickel-Iron Deposit for the Higher Strength Welding of Cast Irons, Particularly SG Irons

#### IDENTIFICATION

**Coating** - Black **Tip** - Green **Imprint** - WIA SC NiFe

#### CLASSIFICATION

- > AWS A5.15: ENiFe-CI

#### DESCRIPTION AND APPLICATION

Supercast Ni/Fe is a basic, graphite coated AC/DC electrode for the higher strength welding of cast irons. It is characterised by a soft, smooth arc with low penetration and spatter levels on both AC and DC power sources. Ease of striking is a feature of Supercast Ni/Fe.

This electrode is made from a Nickel-Iron core wire and produces a ductile, machineable weld deposit with the extra strength required for welding SG (Spheroidal Graphite) irons.

Supercast Ni/Fe may also be used for the repair and reclamation of all standard grades of grey cast iron, malleable iron, austenitic cast iron and some grades of mechanite cast iron. It is ideally suited to the dissimilar welding of these irons to steels.

#### OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELDING CURRENT RANGE *(A)	ARC VOLTAGE RANGE **(V)
3.2	350	50 - 100	23

\*Recommended for DC +/- or AC (minimum 45 OCV) operation.  
 \*\*Voltage is determined by arc current and electrode arc length.  
 Arc voltage shown is typical and is only to be used as a guide.

#### TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Ni	S	Fe
1.0	0.42	58.0	0.009	Bal

#### TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	300 MPa
Tensile Strength	500 MPa
Deposit Hardness	200 - 220 HV (30)

#### PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		APPROX. NO. OF RODS PER KG	PART NO.
	PACKET	CARTON		
3.2	2.5	12.5	39	SNIFE32

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