

SUPERON SCHWEISSTECHNIK INDIA LTD.

World Class Welding Electrodes In Technical Collaboration with M/s Kjellberg Finsterwalde gmbh, Germany.

Ferro nickel electrode

SUPERCAST 55 NiFe-C1

Classification DIN 8573: AWS A 5.15: E NiFe-C1 E NiFe-1 BG11

Description and applications

Graphite basic coated electrode with a Ferro-Nickel alloy deposit for joining and repairing nodular cast iron. Deposit homogeneous and highly resistant against cracks. Particularly recommended for dissimilar welding of cast iron to steels and constructions of cast iron. Good bonding and flow of the weld metal. Defect in foundries, repairing of engine blocks, houses of tool machines, gearboxes, reducing parts, pump bodies, cast pieces, valve bodies.

Base materials Grey cast iron, malleable and nodular cast iron:

> **ASTM** : A48 class 25B to 60B

: A536 Grade 60-80

DIN : GG-15 to GG-40

> : GGG-40 to GGG-60 : GTS-35 to GTS-65

NFA : FLG 150 to FLG 400

> : FGS 400-12 to FGS 600-3 : MN350-10 to MN650-3

All weld metal mechanical properties

R _m (N/mm²)	Hardness	
> 480	190 HB	

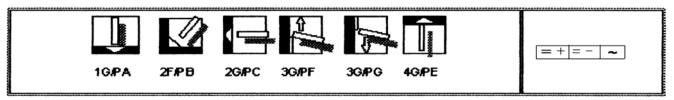
Typical weld metal composition (%)

Ni	FE & OTHERS	
50%	BALANCE	

Amperes (A)

2.5	3.15	4.0
60	80	120

Welding instruction Reduce the heat input to a minimum, keep temperature low (maxi temperature 70°C) in order to reduce the risk of cracks in the base metal. Depose short beads of about 3 cm and peen immediately. Reignite on the weld metal. Weld on clean and exempt from grease surfaces (previous grinding of the joint).



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