

Ferro nickel electrode

STARBLAZE CI 35

Classification **AWS A 5.15 ~ E NiFe-CI**

Description and applications

Graphite basic coated electrode with a Ferro-Nickel alloy deposit for joining and repairing nodular cast iron. Deposit homogeneous, machinable and highly resistant against cracks. Recommended for repairing of engine blocks, houses of tool machines, gearboxes, reducing parts, pump bodies, cast pieces, valve bodies etc.

Typical Weld Metal Chemical Composition(%)

Ni	Fe & Others
35.00	Balance

All weld metal Mechanical Properties (Typical)

Tensile strength R _m (N/mm ²)	Hardness (HB)
≥ 500	210 - 240

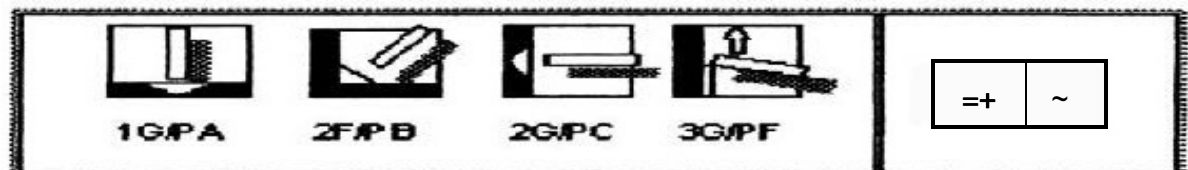
Amperes (A)

2.50mm	3.15mm	4.00mm
50-70	70-100	90-130

Welding instruction

Clean welding area carefully and remove cast skin, grease, oil etc. from base material. Reduce the heat input to minimum, therefore weld bead width should not be more than twice of electrode diameter and length maximum 10 times. Peen /hammer deposited metal just after welding.

Welding Positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850

Plant 1: A-125, Okhla Industrial Area, Phase 2, New Delhi - 110020

Corporate Office & Plant 2: 552, Pace City II, Sector 37, Gurugram, Haryana - 122001

Plant 3: B-100, Mayapuri Industrial Area, Phase-1, Near Police Station, New Delhi-110064

Plant 4: A-334, RIICO Industrial Area, Karoli, Bhiwadi, Rajasthan - 301707

Tel: +91 124 4499523 | Email: sales@starblazeindia.com | Website: www.starblazeindia.com