

Ferro nickel electrode

STARBLAZE NiFe-CI

Classification **AWS A 5.15:** E NiFe-CI **DIN 8573:** E NiFe-1 BG11 **EN ISO 1071-** EC NiFe 1

Description and applications Graphite basic coated Ferro-Nickel alloy electrode for joining and repairing nodular cast iron. Deposit homogeneous, machinable and highly resistant against cracks. Porosity free welding. Recommended for dissimilar welding of cast iron to steels and construction of cast iron. Repairing of engine blocks, broken heavy casting, houses of tool machines, gearboxes, reducing parts, pump bodies etc.

Base Materials **Grey cast iron, malleable and nodular cast iron:**

ASTM	DIN	NFA
: A48 class 25B to 60B : A536 Grade 60-80	: GG-15 to GG-40 : GGG-40 to GGG-60 : GTS-35 to GTS-65	: FLG 150 to FLG 400 : FGS 400-12 to FGS 600-3 : MN350-10 to MN650-3

Typical Weld Metal Chemical Composition(%)

Ni	Fe & Others
50.00	Balance

All weld metal Mechanical Properties (Typical)

Tensile Strength R_m (N/mm ²)	Hardness (BHN)
≥ 500	190 - 220

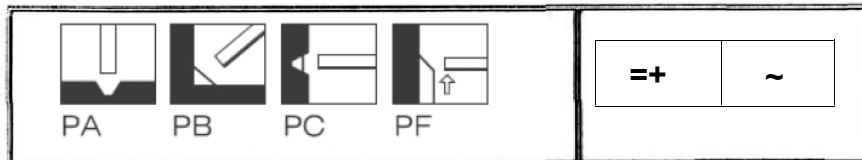
Amperes (A)

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

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