

STARCAST Nife

ELECTROD SPECIAL / SPECIAL ELECTRODE



CLASIFICARE / STANDARDS

AWS A5.15:	E Nife-CI	
DIN 8573:	E NiFeG3	
EN ISO 1071-A:	E NiFeBG23	

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Electrod fabricat cu o sarma de tip Ni-Fe si invelis grafitic, destinat sudarii fontelor, in special fontelor globulare. Metalul depus asigura proprietati mecanice ridicate si nu prezinta porozitati sau fisuri. Metalul depus poate fi prelucrat.

MAIN FEATURES

Electrode having an iron-nichel core wire and graphitic coating; it is suitable for welding of all kind of cast iron, particularly globular, white, black cast iron. Deposited weld metal ensures high mechanical properties and weld metal is free from porosities and cracks. Perfectly suitable for machining.

DOMENII DE APLICATIE

Industria constructoare de masini;
Batiuri de masini.

MAIN APPLICATIONS

Industrial machinery construction;
Coachbuilders.

POZITII DE SUDARE / WELDING POSITIONS



1G 2F 2G 3G 4G AWS
PA PB PC PF PE EN

CURRENT / CURRENT: DC+, AC

RANDAMENT / EFFICIENCY: 100%

ANALIZA CHIMICA A METALULUI DEPUȘ / ALL - WELD METAL CHEMICAL ANALYSIS %

C	Mn	Si	S	Cu	Ni	Fe	Al		
≤ 2.00	≤ 1.00	≤ 2.50	≤ 0.03	≤ 2.50	45.0 - 60.0	≥ 30.0	≤ 1.00		

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	HB	
Stare sudată/As welded	400 - 579	296 - 434	6 - 18	165 - 218	
Dupa/after 610°C x 1h					

DEPOZITARE - CALCINARE

A se pastra in locuri uscate la temperatura camerei.
Odata deschis pachetul, a se pastra la temperatura de 90° - 150°C.

STORAGE - REBAKING

Keep dry and store at room temperature.
Once opened, store at 90° - 150°C till used.

CURENTI DE SUDARE / AMPERAGE

2.50	3.20	4.0							
30 - 80	50 - 100	80 - 130							

AMBALARE / PACKING (vacuum pack mediu)

Diametru	mm	2.50	3.20	4.0					
Lungime / Lenght	mm	300	350	350					
Greutate pe electrod / Weight per electrode	g	15.1	30.0	48.0					
Nr de fire pe pachet / Pcs. per innerbox	n°	65	75	55					
Greutate pachet / Weight per innerbox	kg	1.0	2.3	2.6					
Nr de fire pe cutie / Pcs. per outerbox	n°	780	450	330					
Greutate pe cutie / Weight per outerbox	kg	12.0	13.8	15.6					
Cod / Code		W0002 89009	W0002 89010	W0002 89011					

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.