



# Elgaloy Cast-NiFe

REPAIR & MAINTENANCE

Other

Date:	2016-09-08
Revision:	17

### Description:

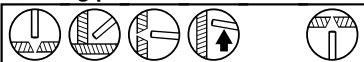
Elgaloy Cast-NiFe is designed to produce a higher, matching strength weld metal for joining malleable, nodular and S.G. irons. It is also suitable for joining these to mild, low alloy and stainless steels.

Elgaloy Cast-NiFe is less sensitive to hot cracking sometimes caused by impurities in castings, compared to pure nickel type electrodes. Thin sections can be welded cold, but thicker sections may require preheat of approx. 150-300 °C. When welding without preheat, use low heat input method. Lightly peen weld beads during welding of thicker sections. On completion allow the workpiece to cool slowly. The deposit is fully machinable.

### Applications:

Spheroidal graphite, nodular and ductile cast irons e.g, machine bases, transmission housings, gear boxes, engine blocks and pump bodies.

### Welding positions:



### Coating type:

Special

### Redrying temperature:

150 °C, 2h

### Hardness as welded:

180-200 HV

### Welding current:

DC+/-, AC

### Chemical composition, wt.%

	C	Ni	Fe
Min	0,9	50	
Typical	1,0	54	bal.
Max	2,0	56	

### Mechanical properties

#### Specified

Yield strength, Rp0.2%:

Tensile Strength, Rm:

Elongation, A5

#### Typical

320-360 MPa

400-450 MPa

8%

### Classification:

EN-ISO 1071  
AWS A5.15-90

E C NiFe-1 3  
E NiFe-CI

### Approvals:

### Product data:

Dim.mm	Product code	Current A		
2,5x300	70522510	50-90		
3,2x350	70523210	80-120		