## Standards

| | |
|---|---|
| TS 9463 EN ISO 1071 | : E C NiFe-CI 1 |
| EN ISO 1071 | : E C NiFe-CI 1 |
| AWS A5.15 | : E C NiFe-CI |

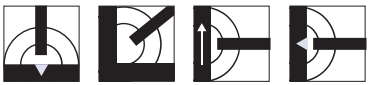
## Mechanical Properties

| **Tensile Strength** ($N/mm^2$) | **Elongation** (($L_o=5d_o$) (%)) | **Hardness** (HB) |
|---|---|---|
| 450 | min. 10 | ~190 HB |

## Features and Applications

- Include machine bases, pump casing, gear housing, gear boxes, engine blocks, compressors, machines frames, dies, flanges, tables, levers and generators
- Low-heat-input manuel electrode for repair and maintanence of cast iron and for joining cast iron with steels or copper alloys. Its excellent weldabilitymakes it easy to use in position.
- It also suitable for joining and building cast irons
- Weld deposit can be machinable by cutting tools
- It has high tensile strength and ductility and nodular graphite deposit resists to cracking
- For semi-hot and cold welding techinque of parts made of grey cast iron , malleable cast iron or nodular graphite cast iron, some nickel and copper alloys such as housing and frames of machinery, subject to dynamic and heavy load
- Weld metal recovery is more than 100 %

## Welding Positions



## MIG & TIG Wire

GeKaTec NiFe SG

## Current Type

D.C.(+)

## Operating Data

| **Product Code** | **Diameter x Length** (mm) / (inch) | | **Welding Current** (A) | **Package Weight** (Kg) | **Weight** g / 100 pcs |
|---|---|---|---|---|---|
| 3030100017 | 3.20 x 350 | 1/8 x 14" | 80 - 120 | 5 | 3100 |
| 3030100018 | 4.00 x 350 | 5/32 x 14" | 120 - 150 | 5 | 4530 |

**Approvals:** GOST-R, CE, SEPRO