

**Standards**

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

**Chemical Composition of  
Weld Metal % (Typical)**

Fe	Ni
>40.0	>45.0

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)	Hardness (HB)
200	350	6	~190

**Features and Applications**

- Welding of grey cast iron, temper cast iron
- Joint welding of cast iron with hard-to-weld steels or cast parts
- Ni-Fe cored stick electrode
- Welding in short passes, and hammering the bead of each pass through gentle strikes are required

**Welding Positions**

**Current Type**

D.C.(+)

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101683	2.50 x 300	3/32 x 12"	60 - 90	1790
3010101690	3.20 x 300	1/8 x 12"	80 - 120	2670
3010101697	4.00 x 400	5/32 x 16"	110 - 150	5390

**Approvals:** CE, SEPRO, TSE