

Standards

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

Mechanical Properties

Tensile Strength (N/mm ²)	Elongation ((L ₀ =5d ₀) (%))	Hardness (HB)
450	min. 10	~190 HB

Features and Applications

- Include machine bases, pump casing, gear housing, gear boxes, engine blocks, compressors, machine frames, dies, flanges, tables, levers and generators
- Low-heat-input manual electrode for repair and maintenance of cast iron and for joining cast iron with steels or copper alloys. Its excellent weldability makes 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 technique 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

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
3030100012	2.50 x 250	3/32 x 10"	60 - 90	4	1560
3030100014	3.20 x 350	1/8 x 14"	80 - 120	5	3100
3030100016	4.00 x 350	5/32 x 14"	120 - 150	5	1560

Approvals: CE, SEPRO