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

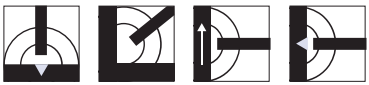
Mechanical Properties

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: CE, SEPRO