

# Product: SPARKWELD NiFe

**Classification:** AWS/ASME SFA-5.1 E NiFe CI

DIN 8573 E NiFe-1 BG-22

**Application/Properties:** Electrode with Nickel Iron core wire used for cold welding of

Iron. The weld metal is non machinable.

**Suitable for:** Grey Cast Iron.

White & Black Heart Malleable Cast Iron

Ductile Iron

High Strength Cast Iron

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| **Sizes and Currents**  **AC or DC:** | Diameter | Length | Current (A) |
| 2.6mm  3.2mm  4.0mm | 350mm  350mm  350mm | 60 - 80  80 - 120  110 - 150 |

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| **Weld metal analysis:** | C | Fe | Ni |
| 0.50 | Balance | 55.0 |

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| **Mechanical properties**  **of all weld metal:** | Yield Strength | >300 N/mm2 |
| Tensile Strength | 420 - 460 N/mm2 |
| Elongation | >10% |
| Hardness | HB 170 |

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|  | 2.6, 3.2 & 4.0mm | 1x10kg. packet/carton |
|  | 1 MT/pallet |