

ROCAST- FN

ELECTRODE DEPOSITING FE-NI FOR MACHINABLE
WELDING OF CAST IRON

BASIC ALLOY: C, FE, NI
AWS/SFA-5.15: ENI FE-CI
EN ISO 1071 E C NIFE-CI3

KEY FEATURES:

A medium coated, ferro-nickel core wire electrodes specially designed to weld cast iron components in cold conditions. The deposit is soft and machinable, retains strength, enable to weld large cast iron castings, and produces crack free joints.

APPLICATIONS

- Suitable to weld and repair all types of Cast Iron components
- Broken casting, joining cast iron to steel
- Cast iron components subjected to wear and tear etc
- Also suitable for underplating of Hardfacing

RE-DRY CONDITION

- Re-Dry the electrode at 150°C for 1 hour.

WELDING NOTE:

1. Clean the weld area free of any surface contaminations.
2. Preheating of the job between 250°C - 500°C may be necessary according to the amount of weld metal to be deposited and the size and type of casting.
3. After the welding is completely with a layer of asbestos or dry lime until it attains room temperature.

CHEMICAL COMPOSITION:

C	Mn	Si	Ni	Fe
0.80-2.00 Max	1.00 Max	1.00 max	50 Min	Balance

WELD METAL HARDNESS:

Hardness
170-190 VPN

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+/ AC) Amps	Wt. of /pkt.	Wt. of Case
2.50/ 2.40	3/ 32"	50-70	2	10
3.15/ 3.20	1/ 8"	80-100	2	10
4.00	5/ 32"	110-140	2	10
5.00	3/ 16"	130-180	2	10