ENI 416 (NiFe)

Coated Electrode for Cast Irons -

Standards

AWS/ASME SFA - 5.15	ENiFe-CI
EN ISO 1071	E C NiFe-CI 3
TS EN ISO 1071	E C NiFe-CI 3

Materials

DIN
GGG 40.3 - GGG 70
GTS 35-10 - GTS 70-02
GTW 35-04 - GTW S 38-12

Properties and Applications

Electrode having a nickel-iron core wire, for welding cast iron with or without preheating. The weld metal features a low coefficient of thermal expansion and as a result, little shrinkage. It has higher strength properties than pure nickel weld metal and is therefore preferably used for welding nodular cast iron, white and black heart malleable cast iron, as well as austenitic nodular cast iron or joining these metals to components made of steel, copper or nickel materials. Easy arc striking and restriking, stable arc, smooth bead. Weld metal is machinable. Weld short beads.

Typical Chemical Values of Weld Metal

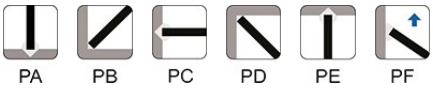
Type of Analysis	C	Si	Mn	Ni	Al	Fe
Weld Deposit	0.45	1.60	0.65	52.00	0.80	44.50

Typical Mechanical Values of Weld Metal

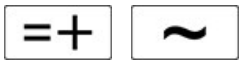
Test Condition	Hardness (HB)
As welded	210

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
4.00x350	110-140
3.25x350	80-110
4.00x400	110-140
2.50x300	50-80
3.25x300	80-110

Packaging Information

Product Code	Diameter X Length (mm)	Pieces per Box (~)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
16003GBEM2	2.50x300	60	1.0	12	13.7	Plastic Box
16003GDEM2	2.50x300	160	2.5	3	8.0	Plastic Box
16003GJEM2	2.50x300	112	1.8	10	18.2	VAC Box

16003MBEM2	3.25x300	37	1.0	12	13.7	Plastic Box
16003MDEM2	3.25x300	93	2.5	3	8.0	Plastic Box
16003MJEM2	3.25x300	65	1.8	10	18.2	VAC Box
16003NJEM2	3.25x350	64	2.0	10	0.0	VAC Box
16003QJEM2	4.00x350	44	2.0	10	0.0	VAC Box
16003RBEM2	4.00x400	32	1.8	10	19.0	Plastic Box
16003RJEM2	4.00x400	48	2.5	9	23.1	VAC Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
It has to be dried at 150°C for 1 hour.