

GRICAST NF

IDENTIFICATION

Gricast NF, E Ni -Fe-CI

CLASSIFICATION

AWS/SFA 5.15 :E Ni -Fe-CI

DESCRIPTION

An extruded, Nickel Iron electrode for cold welding of cast iron. Weldable in all positions. It has a soft and stable arc, having good striking and restriking properties. The weld metal including the heat affected zone is easily machinable. The crack resistance and toughness properties of weld metal are better than that of GRICAST-N or GRICAST-CN and also the weld deposit matches the colour of the parent metal better than GRICAST -N or GRICAST-CN.

WELD METAL ANALYSIS (RANGE) %

C	Mn	S	Si	P	Cu	Ni	Al	Fe
2.0 max	2.5 max	0.03 max	4.0 max	0.03 max	2.5 max	45.0 - 60.0	1.0 max	Rem.

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	Hardness (BHN)
400 - 579	296 - 434	Jun-18	165 - 218

TYPICAL APPLICATIONS

Joining, repairing and surfacing of all types of weldable cast iron including Grey / Nodular and high phosphorous types without preheating of the parent metal.

WELDING INSTRUCTIONS

- For building up the part, the electrode should be connected to D.C.+ polarity to reduce the transfer of heat to the work piece.
- To obtain flat bead the electrode is to be connected to D.C. polarity.
- By using A.C., the effect will be in between the aforementioned D.C. conditions, pre-heating of the parent metal is not necessary.

PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS DC (+)	Packing / Box (kg)
2.5	350	40 - 80	2 x 5 = 10
3.15 / 3.20	350	70 - 120	2 x 5 = 10
4	350	90 - 140	2 x 5 = 10
5	350	110 - 170	2 x 5 = 10