PRODUCT DESCRIPTION

The PROWELD SuperFonte NiFe-CI welding electrode is a high-quality nickel-based electrode specifically designed for welding cast iron materials. It is formulated to provide exceptional strength, crack resistance, and machinability when welding and repairing various cast iron components.

KEY FEATURES

Nickel-Based Alloy: The PROWELD SuperFonte NiFe-CI electrode is composed of a nickel-based alloy, offering excellent weldability and compatibility with cast iron materials.

Superior Strength and Crack Resistance: This electrode is designed to deliver superior strength and crack resistance, ensuring reliable and durable welds in cast iron applications.

Machinability: The welds produced with the PROWELD SuperFonte NiFe-CI electrode exhibit excellent machinability, allowing for easy post-weld machining and finishing.

Low Heat Input: This electrode operates at a low heat input, minimizing the risk of heat-affected zone (HAZ) cracking and distortion, especially in thin cast iron sections.

Versatile Welding Positions: The PROWELD SuperFonte NiFe-CI electrode is suitable for all welding positions, including vertical, horizontal, and overhead welding, offering versatility and convenience in different welding applications.

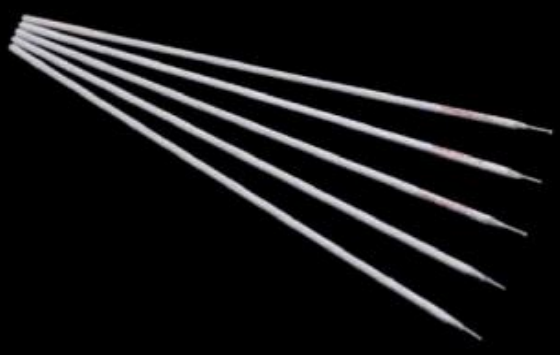
APPLICATIONS

The PROWELD SuperFonte NiFe-CI electrode is commonly used in various applications, including:

- Repair and maintenance of cast iron components, such as engine blocks, manifolds, pump housings, and gearboxes.
- Welding of cast iron pipes, fittings, and valves
- Joining of cast iron to other materials, such as steel or stainless steel
- Fabrication of molds, patterns, and dies made from cast iron
- General welding and repair projects involving cast iron materials

DIAMETERS

2.5MM - 3/32", 3.2MM - 1/8", 4.0MM - 5/32", 5.0MM - 3/16"



DIAMOND
PROWELD SUPER FONTE

Cast Iron Welding Electrodes

CLASSIFICATION

AWS A5.15/ASME SFA A5.15.: ENiFe-CI

CHEMICAL COMPOSITION OF WELD METAL ANALYSIS (%) (TYPICAL VALUES)

	C	Cr	Mn	Mo	Ni	Si	V
Weld Metal Analysis (%)	0.11	0.02	0.28	<0.01	0.02	0.14	0.01
AWS Spec (Max)	0.2	0.2	1.2	0.3	0.3	1	0.08

MECHANICAL PROPERTIES OF ALLWELD METAL

	As Welded	AWS Spec (min)
Ultimate Tensile Strength	73,000 psi (504 MPa)	60,000 psi (414 MPa)
Yield Strength	63,000 psi (432 MPa)	48,000 psi (331 MPa)
Percent Elongation in 2"	26%	22%
Reduction of Area	64%	Not required
CVN @ -20°F	52 ft•lbf (70 Joules)	20 ft•lbf (27 Joules)

WELDING PARAMETERS

Recommended welding parameters for the E - NiFe-CI electrode may vary depending on the specific welding application, base material, and joint configuration. It is crucial to refer to the manufacturer's guidelines and conduct proper testing to determine the optimal parameters for your specific requirements.

STORAGE & HANDLING

To ensure the electrode's performance and longevity, please observe the following storage and handling recommendations:

- Store the electrodes in a dry environment at temperatures between 50°F to 100°F (10°C to 38°C).
- Keep the electrodes in their original packaging or a suitable container to protect them from moisture, dust, and other contaminants.
- Avoid exposure to extreme heat, humidity, or direct sunlight.
- Handle the electrodes with clean, dry gloves to prevent contamination.

Manufactured by;

SHANGHAI INDUSTRIES (PVT) LTD.
Manufacturers of Arc Welding Electrodes

Exclusively Manufactured for;

MILLWALA WELDING COMPANY PVT. LIMITED