

CORODUR[®] NiFe 36

CLASSIFICATION:

Special Alloy
Alloy No.
1.3912

GENERAL CHARACTERISTICS:

NiFe 36 is a Ni- Fe- alloyed flux cored wire electrode for welding cast iron, joining steel and cast iron and cast cavity welding. This alloy has an extremely low coefficient of thermal expansion and is machinable up to GGG 45.

APPLICATION:

Joint welding and repair welding of cast iron, centrifugally cast, malleable cast iron etc.
GG 10 - GG 40, GTS 35 – GTS 70, GTW 35 – GTW 70, GGG 40 – GGG 80

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Ni	Fe
max. 0,1	< 1,0	3,0	36,0	bal.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness of weld deposit: 140 -160 HB

PARAMETER:

Diameter	Voltage	Amps
1,2	20 - 24	150 - 200
1,6	22 - 26	180 - 240
2,0	25 - 27	220 - 260
2,4	25 - 27	260 - 300
2,8	26 - 28	280 - 340

FORMS OF DELIVERY:

Coil "BS 300" = 15 kg | Coil "BS 450" = 25 kg | Drums = 300 kg

G = gas shielded