MIDALLOY MASTERCOR ENiFe-CI FLUX-CORED WIRE

CLASSIFICATION

- Chemistry conforms to AWS/SFA 5.15 for ENiFe-CI coated electrode. (Presently there is no AWS class for flux-cored types of this alloy group).

DESCRIPTION

- MIDALLOY MASTERCOR ENiFe-CI is a flux-cored nickel alloy cored wire designed for welding cast iron.
- This wire has as high a deposition rate as solid wire, but with lower amperage, thus less heat input.

APPLICATIONS

- MIDALLOY MASTERCOR ENiFe-CI is used in the flat position for joining, building-up, and repairing cast iron parts and castings.
- This product provides a hard deposit that is not easily machinable, but can be used for multiple layers.
- When welding cast iron, always preheat and slow cool.
- Convex beads are desired, and peening is necessary after each weld.

TYPICAL CHEMISTRY

C	Fe	Ni	Mn	Si	S	Cu	Al	Others
0.90	45.0	55.0	3.75	0.35	.001	0.10	0.35	<1.0

MECHANICAL PROPERTIES

TENSILE STRENGTH	80,000 PSI Min.
ELONGATION	30% Min.

WELDING PARAMETERS

SIZE	VOLTS	AMPS	STICKOUT	SHIELDING GAS
.045"	25-26	170-220	3/8" – ½"	CO_2 or Ar/CO_2 mix
1/16"	26-27	220-270	3/8" – ½"	CO_2 or Ar/CO_2 mix

STANDARD PACKAGING

- 33 lb. spool

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