

**ROYAL CAST – Fe - Ni (36%) (E Ni Fe – Ci (Mod))**AWS / SFA :5.15 E Ni Fe – Ci (Mod)  
IS: 5511-1991 E Ni Fe (Mod)**Applications**

Ideally suited for joining various types of cast iron such as grey cast iron, nodular cast iron, malleable cast iron. Rectification of defective casting in cast iron foundry, engine heads, pumps, casing impellers, rope drums, ingot moulds. Repairing of various types of cast iron parts.

**Characteristics on Usage**

It is a medium coated Nickel-Iron alloy type electrode, specially designed for welding cast iron parts. It produce's high strength ductile and machinable weld with match parent metal. It is running in flat position with soft and smooth arc low spatters and smoke and the weld metal is crack resistant and has good machinability. Suitable for repair and joining components of various type of cast iron, including grey and nodular cast iron parts.

**Notes On Usage**

- 1) Use currents as low as possible .
- 2) Keep the weld metal length less than 50 mm (2 inch) to disperse welding heat.
- 3) The preheat temprature vary in accordance with size,kind and shape of the base metal 100 - 200 °C is appropriate in general.

**Welding Positions**

1G 2F

**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Ni %	Cu %
1.0 – 2.0	0.50 – 1.0	4.0 Max	0.03 Max	0.030 Max	35	2.0 Max

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	HARDNESS
33-44	140 - 190 BHN

**Packing and Welding Current**

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 X 350	1	15	AC / DC (+)	50 - 80
3.15 X 350	1	15		80 – 120
4.00 X 350	1	15		100 – 140
5.00 X 350	1	15		150 – 190

**Packing**

Vaccum packing