

# Classification Of Cast Iron Electrodes As Per TS 9463 EN ISO 1071-2005

ENi Fe-2																
Symbol	Product Structure	Composition Of The Weld Metal %										Symbol	Abbreviation Of The Consumable	Tensile Strength Mpa	Yield Strength Mpa	Elongation %
		C	Si	Mn	P	S	Fe	Ni	Cu	Other Elements						
Fe-1	E, S, T	2.0	1.5	0.5-1.5	0.04	0.04	Rest	-	-	1.0			EC Fe-1			
St	E, S, T	0.15	1.0	0.8	0.04	0.04	Rest	-	0.35	0.4						
Fe-2	E, T	0.2	1.5	0.3-1.5	0.04	0.04	Rest	-	-	1.0			EC St			
Ni-CI	E	2.0	4.0	2.5	-	0.03	8.0	min-85	2.5	2.0			EC Fe-2 TC Fe-2	320	440	8
	S	1.0	0.75	2.5	-	0.03	4.0	min-90	4.0	1.0						
Ni-CI-A	E	2.0	4.0	2.5	-	0.03	8.0	min-85	2.5	1.0			EC Ni CI	200	250	3
NiFe-1	E, S, T	2.0	4.0	2.5	0.03	0.03	Rest	45-70	4.0	1.0			SC Ni-CI	200	250	3
NiFe-2	E, S, T	2.0	4.0	1.0-5.0	0.03	0.03	Rest	45-60	2.5	1.0			EC Ni-CI-A	200	250	3
	E	2.0	4.0	2.5	-	0.04	Rest	40-60	2.5	1.0			E/S/TC NiFe1	290	420	6
NiFe-CI	E	2.0	4.0	2.5	-	0.04	Rest	40-60	2.5	1.0			E/S/TC NiFe2	290	420	6
NiFeT3-CI	T	2.0	1.0	3.0-5.0	-	0.03	Rest	45-60	2.5	1.0			NiFe-CI	250	350	6
NiFeCI-A	E	2.0	4.0	2.5	-	0.03	Rest	45-60	2.5	1.0			NiFeT3-CI	250	350	12
	E	2.0	1.0	10.1	-	0.03	Rest	35-45	2.5	1.0			350 NiFe-CI-A	250	350	4
NiFeMn-CI	S	0.5	1.0	10-14	-	0.03	Rest	35-45	2.5	1.0			EC NiFeCI-A	250	350	4
	E, S, T	1.7	1.0	2.5	-	0.04	5.0	50-75	Rest	1.0			ES NiFeMn-CI	350	450	10
NiCu-A	E, S	0.35-0.55	0.75	2.3	-	0.025	3.0-6.0	50-60	35-45	1.0			SC NiFeMn-CI	350	450	15
NiCu-B	E, S	0.35-0.55	0.75	2.3	-	0.025	3.0-6.0	60-70	25-35	1.0			EC NiCu	190	300	15
Z	R, E, T	Any Agreed Composition														

  

Symbol	Production Type	Weld Metal Recovery Rate (%)	Current Type
1	Coated Electrodes	≤105	AC-DC
2	Wires or Rods	≤105	DC
3	Flux-Cored Wires Of Flux-Cored Rods	>105≤125	AC-DC
4	Cast Iron Welding Rods	>105≤125	DC
5	Cast Iron Welding Rods	>105≤125	AC-DC
6	Strips	>105≤125	DC
7	Sintered Rods, Strips Or Flux-Cored-Strips	>160	AC-DC
8	Metal Powder	>160	DC

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