CHC408

Nickel-Ferro Cored Covered Welding Rod
for Cast Iron

AWS A5.15 ENiFe-CI
ISO 1071 - E C NiFe-CI 1
GB/T 10044 EZNiFe-1

Type of Covering: Graphite
Welding Position: F, H, HF, OH, V
Type of Current: DCEP or AC

Features & Applications

CHC408(ENiFe-CI) is a cast iron welding rod with Nickel-Ferro core with stronge reducible graphite coating.It has features of high strength, good plasticity, lower coefficient of linear expansion. The color of coating is black and reddish, the arc is stable and the melt droplet transition is fine.Also the coating melts evenly, the slag coverage is excellent, and the weld performance is beautiful. Especially for low current, it has excellent operating performance and can avoid the adverse effects of high current.

CHC408(ENiFe-CI) is suitable for welding important and high-strength gray cast iron or nodular cast iron, such as cylinders, engine seating, gears and so on.

Chemical Composition of Deposited Metal (%)

	C	Mn	Si	S	Fe	Al	Ni	Cu	Other	
Standard	≤2.0	≤2.5	≤4.0	≤0.03	---	≤1.0	45~60	≤2.50	≤1.0	
Atlantic	0.71	0.24	1.00	0.007	---	0.054	54.00	0.055	---	

Recommended Current (DCEP or AC)

Diameter(mm)	2.5	3.2	4.0	5.0
Length(mm)	295	345	345	345
Current(A)	50-80	80-100	110-140	150-180

Notice: 1) The rod should be baked at 150℃ for 1~1.5 hour before use

2) Small current is recommended.

3) The surfaces to be welded must be cleaned away impurities of oil contamination, rust, moisture and so on.