

Characteristics:

LKE-NiFe-CI is a covered electrode with graphite type coating and Fe-Ni alloy core rod. The weld metal provides low expansion coefficient, less hardening and good machining property. It is suitable for ductile cast iron, malleable cast iron and gray cast iron.

Applications:

For repairing of mining equipment, engine blocks, marine equipment and other heavy manufacturing equipment.

Notes on Usage:

1. Hot peening prevent the shrinkage stress.
2. Clean up to prevent contamination.
3. Preheat the base metal at 300 °C, PWHT at 500-600°C.
4. Use small amperage and keep the arc as short as possible.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Ni
1.06	0.29	1.75	0.005	0.005	49.80

Typical mechanical properties of weld metal

TS N/mm ²	Vicker's Hardness (HV)
520	170-220

Welding position:



Sizes and recommended current range

Diameter (mm)	2.6	3.2	4.0	5.0
Length (mm)	300	350	350	350
Current Range	60-80	80-120	120-150	130-180
Weight per pack(kg)	5	5	5	5
Weight per carton (kg)	20	20	20	20