



Cast Iron, Non Ferrous & Others



Code & Specification

ASME SFA/AWS A5.15 E NiFe-CI

Description

BLUME[®] E NiFe-CI is a Ni-Fe type machinable electrode for Repair and Welding of Cast Iron. Produces dense, soft and ductile weld with adequate strength. Provides porosity are welding. Controlled dilution and penetration. Does not require preheating for large heavy casting.

Applications

BLUME[®] E NiFe-CI is used for repair of broken heavy casting along with welding and repairing of all cast iron components. Main items used to repair are pump casting and gears, cast iron dies, gear boxes and gear teeth.

Mechanical Properties

Specification	Condition	Hardness (3 Layer), BHN
	As Welded	150-190

Redrying Condition : 150°C (300°F) for 1 Hour

Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	S	Cu
≤ 2.0	≤ 2.50	≤ 4.0	≤ 0.03	≤ 2.5
Ni	Fe			
45.0-60.0	3.0-6.0			

Packaging

Ø x L	Amperage, A	Wt./Carton	Carton/Box	Net wt./Box
2.5mm x 350mm (3/32" x 14")	40-70	1 kg (2.2 lbs)	10	10 kgs (22 lbs)
3.2mm x 350mm (1/8" x 14")	70-110	1 kg (2.2 lbs)	10	10 kgs (22 lbs)
4.0mm x 350mm (5/32" x 14")	90-120	1 kg (2.2 lbs)	10	10 kgs (22 lbs)

Approvals



Blumenotics Pvt. Limited

An ISO 9001:2015 Company

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