



## **M-90 ENife-CI**

### **FEATURES**

- \*HIGH IMPACT TOUGHNESS AS LOW TEMPERATURE
- \*GOOD ARC & SLAG STABILITY AND HOT CRACKING RESISTANCE
- \*GOOD PRODUCTIVITY

### **APPLICATION**

- \*Basic coated electrode which deposits a machinable nickel iron alloy weld.
- \*Designed for strength welding of high duty cast iron such as mechanite, malleable and spheroidal graphite and nodular irons.
- \*Welds high phosphorus castings.
- \*Typical components to be welded are machine bases, pump bodies, engine blocks, gears and transmission housings.

### **CLASSIFICATION**

- \*A5.15/ ASME SFA5.15 ENiFe-CI

### **CHEMICAL COMPOSITIONS**

C	Si	Mn	P	S	Fe	Ni	MO
1.73	0.59	1.35	0.005	0.001	45.7	55.00	

### **HARDNESS**

Hardness (HRB)
90.0

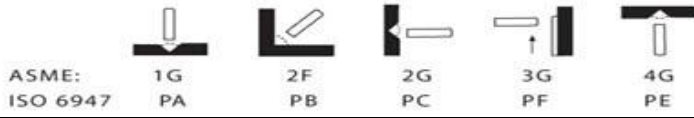
### **WELDING PARAMETERS**

DIAMETER (mm)	2.5	3.2	4
LENGTH (mm)	350	350	350
CURRENT (amps)	60-90	80-130	110-160

### **CURRENT**

- \*AC or DC +/-

## WELDING POSITIONS



**Current**

= +	~	(U <sub>o</sub> : 60V)
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