

CORODUR[®] NiFe 60/40

CLASSIFICATION:

Special alloy

GENERAL CHARACTERISTICS:

CORODUR NiFe 60/40 is a iron alloyed nickel based tubular wire.

The physical property of CORODUR NiFe 60/40 makes it suitable for grey cast iron parts and spherical cast iron. It is machinable. Used for joining and repairing of nearly all types of cast iron. Preheat temperature should be chosen depending on base material and construction.

APPLICATION:

Joint welding and repair welding of:

GG 10 - GG 40, GTS 35 – GTS 70, GTW 35 – GTW 70, GGG 40 – GGG 80

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Ni	Fe	Cu
max. 0,5	< 1,0	4,0	bal.	40,0	+

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 160 - 190 HB

PARAMETER:

Diameter	Voltage	Amps
1,2	20 - 24	150 - 200
1,6	22 - 26	180 - 240
2,0	25 - 27	220 - 260
2,4	25 - 27	260 - 300
2,8	26 - 28	280 - 340

FORMS OF DELIVERY:

Coil "BS 300" = 15 kg

Coil "BS 450" = 25 kg

Drums = 300 kg

G = gas shielded