

# PRODUCT DATA SHEET

## Afrox Ferroid 3



Afrox Ferroid 3 is an all-positional electrode depositing a nickel iron alloy weld which is machinable without undue difficulty. The weld metal after machining provides a close colour match with the casting. The electrode has a smooth soft arc and is easy to use with a small slag volume, which is readily removable.

### Applications

This electrode has been specifically designed for the strength welding of high duty cast iron, such as meehanite, malleable and spheroidal graphite or nodular irons. It is ideal for welding thick sections of different types of cast irons to each other or to steel. It can be used to weld high-phosphorous castings and to join thin sections of gray cast iron to themselves or to other ferrous materials. Although preheating is recommended, the electrode can be used where no preheat has been applied.

### Classifications

AWS	A5.15	ENiFe-CI
EN	1071	ENiFe-2

### Typical Chemical Analysis (All weld metal)

% Carbon	2,0 max	% Iron	Bal.
% Manganese	1,0 max	% Nickel	45,0 - 60,0 max
% Silicon	4,0 max	% Copper	2,5 max
% Sulphur	0,03 max		

### Packing Data (DC+ AC 70 OCV min)

Diameter (mm)	Electrode Length (mm)	Current (A)	Pack Mass (kg)	Item Number
2,5	350	70 - 90	5,0	W075822
3,15	350	90 - 120	5,0	W075823
4,0	350	120 - 140	5,0	W075824

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