

PRODUCT DATA SHEET

Afrox Ferrolloid 4



Afrox Ferrolloid 4 is a nickel cored electrode designed to produce machinable welds in cast iron, without any preheat. When used in the recommended manner, the fusion zone is extremely narrow with hard areas of heat affected iron at a minimum. Welds are free from cracks and porosity, and exhibit mechanical properties adequate for cast iron. The colour match of the deposit approximates that of cast iron.

Applications

This electrode has been specifically designed for the rectification and repair of all commercial grades of cast iron, where machining, after welding, is to be carried out. Preheating and post weld heat treatment is not required in many applications where the location of the defect or shape of design is such that high stresses are not developed. Control of heat input is essential, particularly avoiding local heat build-up.

Classifications

AWS	A5.15	ENi-CI
EN	1071	ENi-CI (nearest)

Typical Chemical Analysis (All weld metal)

% Carbon	2,0 max	% Iron	8,0 max
% Manganese	1,0 max	% Nickel	90,9 min
% 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	40 - 90	1,0	W072832
2,5	350	40 - 90	5,0	W075832
3,15	350	60 - 105	1,0	W072833
3,15	350	60 - 105	5,0	W075833
4,0	350	90 - 135	5,0	W075834
5,0	350	150 - 190	5,0	W075835

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