

# AW FERRONILOX 60

## NICKEL AND IRON STICK ELECTRODE

Point ID: White

### AWS CLASSIFICATION

- AWS A5.15/AWS A5.15M / E NiFe-CI
- ASME SFA-5.15/SFA-5.15M / E NiFe-CI

Nickel-iron coated stick electrode (Ni=Nickel, Fe=Iron) for cast iron (CI=Cast Iron) designed to weld in all positions, its deposits are machinable, of good appearance; Material transfer is smooth with easy slag shedding.

### APPLICATIONS

It is used in the repair of grey and malleable cast iron such as machinery bases, motors, pump bodies or impellers, gear boxes, crowns, cams, worn teeth formation in gears, canes, valves, housings, etc., also used in the union of steels with cast irons.

### ADVANTAGES

This is an alloy of nickel and iron of high resistance and great facility to deposit even in pieces impregnated with oil or grease, preferably using the AW 127 as base in difficult cases with low amperage; The deposits of this electrode are machinable, do not leave hard points and can also be used in combination with AW NILOX. It gives good results as a coating against friction wear due to its high degree of polishing.

### WELDING TECHNIQUE

Bevel with electrode (CUT - WELD) or emery on the groove joints and the preparation angle of the groove must be between 60° and 80°, rounding the edges to a better filling. Carefully clean the area to be bonded or coated, use direct current (DC) with the electrode to positive (reversed polarity PI) and deposit short straight strands, lightly hammer each deposit while it is hot and avoid sudden changes in temperature, use the technique of alternating cords to avoid overheating the area. When finished welding, cover the piece with lime or dry refractory sand to achieve the slowest cooling possible, avoid drafts during the application of the weld. Machinable deposit.



## MEASURES & PACKAGING

Millimeter	Inches	Amps
2.4 x 356	3/32" x 14"	65 - 95
3.2 x 356	1/8" x 14"	80 - 110
4.0 x 356	5/32" x 14"	100 - 135

## PACKING

- Plastic canister with 5 kg.

Manufactured by Electrodo Infra:

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Tultitlán, Edo. México.

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