

NFM

CODIFICATION: **AWS :** SFA 5.15 ENiCl

CHARACTERISTICS AND APPLICATIONS:

NFM is an electrode depositing high nickel weld metal for welding of cast irons. The deposit is soft and has good resistance to cracking. Ideally suited for welding of cast iron to produce machinable weld deposit. Also suitable for repairing of cracks filling up and surfacing applications.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Ni	Fe
Percent	: 0.80	0.15	0.80	Balance	4.0

TYPICAL WELD METAL HARDNESS : 150VHN

CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	: 140-180	110-130	80-110	60-80
Weight/Carton (kgs)	: 2.5	2.5	2.5	2.5

APPROVALS: BHEL

PRECAUTIONS

1. Ensure the electrode are dry. In case of moisture pick-up, redry the electrodes at 120°C for one hour.
2. Over heating of casting should be avoided by putting intermittent weld beads
3. Allow the weld to cool slowly.