

CORODUR® NIFE 36

NiFe 36 is a Ni- Fe-alloyed flux cored wire electrode for welding cast iron, joining steel and cast iron and cast cavity welding. This al-

loy has an extremely low coefficient of thermal expansion and is machinable up to GGG 45.



Verbindungs- und Reparaturschweißungen an GGG, Schleuderguss, Temperguss, etc. GG 10 - GG 40, GTS 35 - GTS 70, GTW 35 - GTW 70, GGG 40 - GGG 80.

TYPICAL ALL WELD METAL ANALYSIS (%)

Base = Fe

C	Si	Mn	Ni	Cu
max. 0,1	< 1,0	3,0	36,0	+

Hardness

140-160

CAST IRON ALLOYS

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

Other Dimensions on demand

FORMS OF DELIVERY

Unit	Weight
Coil BS 300	15 kg
Coil B 450	25 kg
Drums	300 kg

G = Gas shielded