

STARCAST NiFe

MMA Electrodes
Cast-iron



STARCAST NiFe is a basic-graphite coated MMA electrodes with nickel-iron core wire, for joining and surfacing of cast iron without or with only a minimum preheating of < 300°C, cast iron cold welding. Higher weld metal strength than STARCAST Ni. Used for welding applications on new cast iron components made of globular gray-cast iron (GJS/GGG) and dissimilar joining of GJS to steel. Suitable for cast iron with globular graphite (GJS), black-heart cast iron (GJMB), white-heart cast iron (GJMW), austenitic cast iron and dissimilar joints to steel. Easy striking, stable arc, finely-rippled bead surface. Weld at low heat input with short beads, ~10 to 30 mm, and hammer peen. Weld metal can be machined.

Classification

EN ISO	1071 : E C NiFe-CI 1
AWS	A5.15: E NiFe-CI

Chemical analysis (Typical values in %)

	C	Mn	Si	Ni	Fe
All weld metal	1-2	0.8	0.8	Rem	43

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Hardness
As Welded	≥ 280	400-580	150-170 HB

Storage

Keep dry and avoid condensation.
Re-drying not generally required.
If necessary: 80 °C for 1 hour, once only.

Current condition and welding position

AC; DC+

