UNITED ALLOYS
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# CASTEX 5

## NICKEL-IRON ELECTRODE FOR WELDING CAST IRON
## AWS - ENiFe-CI

### AC OR DC REVERSE (ELECTRODE +)

## GENERAL CHARACTERISTICS:

A nickel-iron type electrode for welding cast iron in all positions. This electrode produces welds with higher strengths and ductility than the straight nickel electrodes. Deposits are machinable, but harder and more resistant to abrasion than high nickel welds.

## APPLICATIONS:

Welding cast irons and nodular iron and joining these irons to steel and other ferrous and non-ferrous materials. Also for heavy sections of high strength and engineering grade cast iron. Commonly used to weld high phosphorus irons and steels, ductile iron, and high-nickel alloy cast iron.

## TECHNICAL DATA:

Specifications ..... AWS A5.15 class ENiFe-CI
Current ..... AC or DC reverse polarity (electrode+)

| Amperage | 40-95 | 70-125 | 110-160 | 125-190 |
|---|---|---|---|---|
| (in) | 3/32” | 1/8“ | 5/32” | 3/16” |
| (mm) | 2.5 | 3.25 | 4.0 | 5.0 |

## PROCEDURE:

Preheat cast iron parts to 600°F (315°C). Steels and other materials usually do not require preheat unless they are complicated and contain excessive stresses. Use stringer beads or narrow weave beads. Remove slag between passes when making multiple layers. Maintain preheat temperature during entire welding operation; when completed allow part to cool slowly.

Rev. 1/20/2000

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