



ERNiFe-CI

TYPICAL DEPOSIT COMPOSITION		
Element	Requirement (%)	Weld Metal Analysis (%)
Aluminum (Al)	1	0.1
Carbon (C)	2	0.03
Copper (Cu) ¹	2.5	0.1
Iron (Fe)	Balance	44.5
Manganese (Mn)	2.5	0.7
Nickel (Ni) ²	45.0 – 60.0	54
Silicon (Si)	4	0.1
Sulfur (S)	0.03	0.002

Description

ERNiFe-CI is suitable for repair welding and joining various types of cast iron, including applications where cast iron is welded to mild steel. It closely resembles ENiFe-CI, but with a significantly lower carbon content. To reduce the risk of cracking, a preheat and interpass temperature of at least 350°F is generally recommended during welding.

TYPICAL WELDING PARAMETERS				
Process	Diameter	Amperage (A)	Voltage (V)	Shielding Gas
GTAW	3/32"	85 – 170	9 – 15	100% Argon
GTAW	1/8"	100 – 200	9 – 15	100% Argon
GMAW	.035"	150 – 190	24 – 27	75% Argon / Balance Helium
GMAW	.045"	200 – 290	25 – 30	75% Argon / Balance Helium