

## ENI 416 (NiFe)

Coated Electrode for Cast Irons -

### Standards

AWS/ASME SFA - 5.15	ENiFe-CI
EN ISO 1071	E C NiFe-CI 3
TS EN ISO 1071	E C NiFe-CI 3

### Approvals & Certificates

GOST

### Materials

#### DIN

GGG 40.3 - GGG 70

GTS 35-10 - GTS 70-02

GTW 35-04 - GTW S 38-12

### Properties and Applications

Electrode having a nickel-iron core wire for welding cast iron with or without preheating. The weld metal features a low coefficient of thermal expansion and as a result, little shrinkage. It has higher strength properties than pure nickel weld metal and is therefore preferably used for welding nodular cast iron, white and black heart malleable cast iron, as well as austenitic nodular cast iron or joining these metals to components made of steel, copper or nickel materials. Easy arc striking and restriking, stable arc, smooth bead. Weld metal is machinable. Weld short beads.



### Typical Chemical Values of Weld Metal

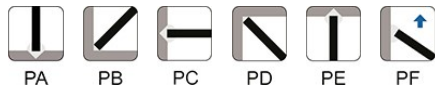
Type of Analysis	C	Si	Mn	Ni	Fe
Weld Deposit	0.40	1.60	0.70	52.50	44.00

### Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HB)
As welded	210

### Application Information

#### Welding Positions



#### Polarity:



#### Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x300	50-80
3.25x300	80-110
4.00x400	110-140

### Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
16003GDEM2	2.50x300	160 AD	2.62	3	8.00	Plastic Box
16003GIEM1	2.50x300	100 AD	1.61	9	14.80	VAC Box
16003GJEM2	2.50x300	112 AD	1.79	9	16.30	VAC Box
16003M9EM1	3.25x300	15 AD	0.33	35	11.60	Blister
16003MDEM2	3.25x300	93 AD	2.62	3	8.00	Plastic Box
16003MJEM1	3.25x300	70 AD	1.94	9	17.70	VAC Box
16003MJEM2	3.25x300	65 AD	1.79	9	16.30	VAC Box

16003RJEM2	4.00x400	48 AD	2.55	9	23.10	VAC Box
16003RKEM1	4.00x400	50 AD	2.67	9	24.20	VAC Box

**Storage & Re-Drying Information**

It can be dried maximum 5 times.  
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.  
It has to be dried at 150°C for 1 hour.