

Standards:

DIN EN ISO 1071: E C NiFe 1 1
 (DIN 8573): E NiFe-1-BG 23
 AWS: E NiFe-CI

capilla[®] 45**Product description:**

Special flux coated stick electrode with a nickel-iron alloyed core wire for repair and maintenance of cast iron.

The welding properties of the electrode are excellent. The seams are free of blow holes. The deposits can be machined excellently.

Carbon is precipitated as graphite in the weld metal.

Applications:

For cold welding of grey cast iron, malleable cast iron and nodular cast iron.

Base metals:

EN 1561: EN-GJL-100 (GG10) to
 EN-GJL-350 (GG 35);
 EN 1562: EN-GJMB-350 (GTS 35) to
 EN-GJMB-550 (GTS 55);
 EN-GJMW-350 (GTW 35) to
 EN-GJMW-550 (GTW 55);
 EN 1563: EN-GJS-400 (GGG40) to
 EN-GJS-700 (GGG 70)

Typical weld metal composition:

[wt. - %]

	C	Ni	Fe
Min.		51	
Max.	1,5	55	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Hardness: 200 [HB]

Positions: all except PG

Redrying: 150 – 180°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,5	350	60 - 90	=(+)~
3,25	350	90 - 120	
4,0	350	110 - 150	

also available:
 find in table of content

Capilla 45-2
 Capilla 45 MIG

Capilla 45 WIG
 Capilla G 45 MM (tubular wire)