



SUNFENI

CLASSIFICATION:

AWS: A 5.15 E NiFeCl

DESCRIPTION:

SUNFENI is an electrode depositing a Ferro nickel alloy weld metal, ideal for welding of several types of cast iron and components for producing strong cracks free weld joints. The weld metal deposit has good machine ability and good colour match with the parent metal.

TYPICAL ALL WELD METAL PROPERTIES:

Chemical Composition (%)				Typical Weld Metal Hardness	
C	1.0 max	Mn	1.0 max	170-190 BHN	
Si	1.50 max	Ni	52-60		
Fe	Balance				

TYPICAL APPLICATIONS:

Ideally suited for welding and repairing of all types of cast iron components, broken castings, joining cast iron steel to steel. Cast iron components subjected to wear and tear etc.

CURRENT RANGE & PACKING DATA:

Size	Length	Current Range	Qty of Electrodes in a	No. of Electrodes in a
(mm)	(mm)	(Amps)	Carton	Cardboard Box
2.5	350	60-80	2 Kg	10 Kg
3.15	350	80-100	2 Kg	10 Kg
4	450	100-140	2 Kg	10 Kg

PACKING:

Electrodes are packed in Cartons and five of these Cartons are shrink wrapped in a cardboard box.