SUPERFONTE Ni

TOP FEATURES

- Easy arc striking, stable arc, finely-rippled bead surface, the weld metal is machinable.
- Weld using a low heat input and weld with short beads, ~10 to 30 mm and in order to reduce weld residual stresses, hammer-peen welds immediately after welding and before cooling.

CLASSIFICATION

AWS A5.15	ENi-CI
EN ISO 1071	E C Ni-CI 1

CURRENT TYPE

AC, DC-

WELDING POSITIONS

All position, except vertical down

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Fe	Ni
0.7	2	Rem

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Hardness (HB)
AWS A5.15	AW	262-414	276-448	3-6	135-218
EN ISO 1071-A	AW	≥200	≥250	≥3	not specified
Typical values	AW	270	445	8	175

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	60-80
3.2x350	75-120

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	125	2.1	W100258507
3.2 x 350	VPMD	83	2.6	W100258508

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.