

SE-Fonte-Ni®

Coated repair electrode pure nickel

The **SE-Fonte-Ni®** coated electrode is a **graphite-basic coated electrode** that deposits **pure nickel metal**. It is particularly recommended for **joining and repairing gray cast iron**, as well as for **crack repair**.

The deposit is **homogeneous, easily machinable**, with **strong adhesion and excellent metal spread**.

PROPERTIES & APPLICATIONS

Weldable Grades, Gray Cast Iron, and Various Steels:

ASTM	DIN	NFA
A48 Class 25B – A48 Class 60B	GG-15 à GG-40	FGL 150 à FGL 400

Maintain heat input between passes as low as possible (maximum temperature of 70°C) to minimize the risk of cracking in the base metal. Use **minimal amperage** and apply **narrow, short beads**.

To **reduce internal stresses in the base metal**, it is recommended to **peen the weld bead after each pass**, which is essential for clamped parts.

Ensure welding is performed on **clean, grease-free surfaces**, with **prior grinding of the joint**.

Main applications : Repair of engine blocks, machine tool frames, gearboxes, reducers, pump bodies, cast parts, and valve bodies.

DEPOSITED METAL COMPOSITION

C	Mn	Si	Fe	Ni
1.2	< 1	< 2	< 2	> 95

MECHANICAL CHARACTERISTICS OF THE DEPOSITED METAL

Hardness	Rm
~ 180 HB	> 300

WELDING PARAMETERS

Ø x L (mm)	2.5 x 350	3.2 x 350	4 x 350	5 x 450
Intensity (A)	70	100	145	180

PACKAGING

4.5 kg Boxes

Groupe BMI

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