

# Product Data Sheet

Hard Facing Electrode

**BRAND NAME** VJ Cast FeNi  
**AWS/ASME Class** ENiFe-CI  
**SPECIFICATION** SFA 5.15



## Features and Applications :

VJ CAST FeNi is a low heat input electrode ideal for welding cast iron and nickel-copper alloys, offering a strong, ductile, and easily machinable weld deposit. It is suitable for repairing grey and nodular cast iron, filling cavities, rebuilding worn surfaces, and welding Monel to itself or to stainless and carbon steels.

Typical applications include the repair of gear teeth, pump impellers, housings, compressors, valves, and gearboxes.

## CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	1.50
Mn	1.00
Si	0.70
Ni	46.00
Cr	0.04
Fe	Rem.

## DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing(Kgs)
	Min	Max	Qty / Pkt
3.15 x 450	100	140	2.0
4.00 x 450	140	180	2.0
5.00 x 450	180	220	2.0

## CURRENT : AC/DC (+)

## OTHER DATA:

Redrying: The electrodes should be redried at 300°C for 1 hour.  
Welding Technique Use stringer bead technique and avoid high current. Use Shorts arc.  
For more information, please feel free to contact us.



Manufactured by :  
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