



Manufacturers of Custom Welding Lines for Resale
www.selectrode.com

SELECTRODE 1144

Ferro-Nickel Cast Iron
 Non Conductive Coating

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.15 E NiFe-CI-A
 ISO 1071: ENiFE

DIN 8573: E NiFe BG13
 NFA 81-342: E Ni BG 13

FEATURES & APPLICATIONS

“Extra Flow” weld metal for rapid repairs.

Universal electrode for joining a wide variety of ductile, nodular and malleable cast irons. Ideally suited for the repair of defective or cracked malleable iron castings.

Nickel - iron “Non Conductive” electrode for joining dirty - contaminated cast irons and cast irons to steel

- Flux coating does not side arc even after being heated.
- Extremely strong arc drive penetrates surface contaminants.
- Special slag composition can be welded over without creating porosity.
- Extra nickel content insures crack resistant machinable welds.
- Also available in TIG form as product code 6044.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Consists of an iron-nickel austenite with finely distributed graphite.

Flux Color: Black

C	S	Mn	P	Si	Al	Cu	Fe	Misc	Ni
1.9	.030	<2.3	--	3.6	.99	.8	<45	1 Max	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength
 Yield Strength
 Elongation
 Hardness

Maximum Value Up to:

70,000 PSI (500 MPa)
 49,000 PSI (350 MPa)
 18%
 Rockwell B 88-90, Brinell 185, Vickers 189

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+), or AC

Diameter	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	50	70	100	130
Maximum Amperage	80	110	140	175

Welding Techniques: Remove any surface contamination with the proper solvents. Adjust the welding machine to the lowest proper setting that yields good welding conditions.

Welding Positions: Flat, Vertical up, Horizontal, Overhead

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings
3/32 (2.5)	12" (300)	.44 oz. (13g)	36 (80)	45 (100)	70
1/8 (3.2)	14" (350)	.76 oz (21g)	21 (47)	24 (55)	90
5/32 (4.0)	14" (350)	1.07 oz (31g)	15 (32)	22 (48)	125
3/16 (5.0)	14" (350)	1.6 oz (45g)	10 (22)	19 (42)	160

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	12" (350)	14" (350)	14" (350)
Electrodes / lb	28	15	6
Electrodes / kg	62	33	13.2