



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 1889

Copper Clad Tri-Metal Non-Overheating Cast Iron

INTERNATIONAL CLASSIFICATIONS

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

DIN 8573: E NiFe-1 BG13
NFA 81-342: E NiFe BG 13

FEATURES & APPLICATIONS

The high deposition rate of this electrode creates an extremely narrow heat affected zone. This feature is suitable for all weldable cast irons that require post weld machining.

One of a kind heavily copper clad “Tri-metal” cored cast iron electrode

- Visually unique core wire creates immediate customer interest.
- High efficiency weld metal transfer totally eliminates electrode overheating.
- Proprietary copper-nickel-iron deposit chemistry yields the ultimate combination of softness, ductility and tensile strength.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

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

Flux Color: Black

C	S	Mn	P	Si	Ni	Cu	Fe
1.1	.012	.9	.004	1.3	53	6.2	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	77,000 psi (550 MPa)
Yield Strength	54,000 psi (380 MPa)
Elongation	30 %
Hardness	Rockwell B 84-88, Brinell 176 Vickers 185

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	50	70	100
Maximum Amperage	70	100	130

Welding Techniques: Guide the electrode at a steep angle keeping the arc length short. Use short staggered

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)	.39 oz. (11g)	42 (92)	45 (100)	60
1/8 (3.25)	14"(350)	.76 oz (21g)	21 (47)	22 (49)	90
5/32 (4.0)	14" (350)	1.07 oz (31g)	15 (32)	20 (45)	120

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	12" (300)	14" (350)	14" (350)
Electrodes / lb	29	14	10
Electrodes / kg	64	32	22