

Standards :

EN ISO 1071 : E NiFe-13
AWS A5.15 : E NiFe-CI

UTP GNX-HD

Graphite-basic coated ferro-nickel stick electrode with high mechanical values

Application field

UTP GNX-HD is suited for repair welds, fabrication weld and surfacing work on all cast iron types, especially for cast iron with nodular graphite GGG 40 to GGG 70, grey cast iron GG 18 to GG 25 and mixed joints with steel or nickel alloys. Good alloying pickup behaviour also on bad cast iron.

Welding characteristics and special properties of the weld metal

UTP GNX-HD has excellent welding properties, stable and spatter free arc, even flow with a high deposit efficiency. Because of the bi-metal core wire, a high current carrying capacity is guaranteed.

Mechanical properties of the weld metal

Yield strength $R_{p0,2}$ MPa	Hardness HB
approx. 340	approx. 220

Weld metal analysis in %

C	Ni	Fe
1,1	balance	45,0

Welding instruction

Remove outer casting skin in welding area. Apply steep stick electrode guidance and short arc. Choose possibly low current settings. Avoid heat accumulation. Iron cast weldments susceptible to stress should be welded in short beads (approx. 30 mm) and then must be thoroughly hammered.

Current type DC (+) / AC

Welding positions


Availability / Current adjustment

Stick electrodes	Ø mm x L	2,5 x 300	3,2 x 350	4,0 x 350
Amperage	A	60 – 90	90 – 120	110 – 150