

Ni-base solid wire

Classification

AWS A5.15 : ENiFe-CI
ISO 1071 : S NiFe-CI

General description

Solid wire for butt welds and hardfacing application in cast iron
Suitable for dissimilar joints cast iron/steel
Hardness approximately 200HB
Optimal welding characteristics

Shielding gases (acc. EN 439)

GMAW	I1	Inert gas Ar (100%)
	I3	Inert gas Ar+ >0-95% He

Chemical composition (w%). typical. wire

C	Mn	Si	Ni	Fe	Cu
0.05	0.83	0.14	54.8	43.8	0.4

Mechanical properties, typical, all weld metal

	Typical hardness values
2 Layers, AW	approx. 200 HB

Packaging and available sizes

Process	Unit	Diameter (mm)	1.2
GMAW	15 kg spool BS300		X

Other sizes and packaging on request

LNМ NiFe: rev. EN 20

Liability: All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request