

Ni-base solid wire

Classification

AWS A5.15-90 : ENiFe-CI
 ISO 1071-01 : 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

Approvals

Chemical composition (w%), typical, wire

C	Mn	Si	Ni	Fe	Cu
0.05	0.83	0.14	54.8	bal.	0.4

Mechanical properties, typical, all weld metal

Typical hardness values

2 Layers, AW approx. 200 HB

Packaging

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

Other sizes and packaging on request