

E NiFe-CI (FN 55)

Nickel Alloy WIRE/GTAW

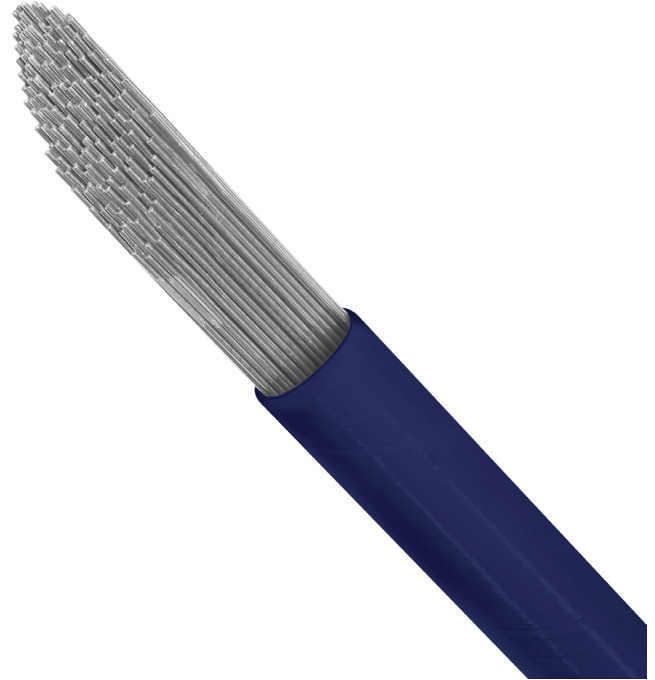
Standards

EN/ISO-Standard - 1071
EN/ISO-Classification - SC NiFe-1

AWS-Standard - A5.15
AWS-Classification - E NiFe-CI

Features and Applications

- Ferro-nickel solid wire used for welding cast iron and ductile iron.
- Suitable for dissimilar joints between cast iron, mild steel, low alloy and stainless steels.
- Recommended for welding high sulphur, phosphorous or lubricant-contaminated castings.
- Typically used for a range of repair and fabrication applications, including rebuilding shafts, wheels, critical joints between steel and cast iron etc.
- **Test Certificates can be found online @wilkinsonstar247.com**



Typical Base Materials

Grey cast iron, malleable, nodular*
* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF

Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

Polarity

DC (-)

Mechanical Properties

| Tensile Strength (N/mm ²) | Yield Strength (N/mm ²) | Elongation (%) | Impact Strength (J) |
|---------------------------------------|-------------------------------------|----------------|---------------------|
| 400 - 579 | - | - | - |

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

Chemical Composition % (Range)

| C % | Mn % | Si % | P % | S % | Fe % | Ni % | Cu % | Al% |
|------|------|------|------|------|------|-------|------|------|
| max | max | max | max | max | rem. | 54.00 | max | max |
| 2.00 | 0.80 | 0.20 | 0.03 | 0.03 | | 56.00 | 2.50 | 1.00 |

Packaging Data

| Part No. | Diameter Ø (mm) | Package Length (mm) | Package Weight (Kg) | Package Type |
|------------|-----------------|---------------------|---------------------|----------------|
| 6011100614 | 1.60 | 1000 | 5 | Cardboard Tube |
| 6011100615 | 2.40 | 1000 | 5 | Cardboard Tube |
| 6011100616 | 3.20 | 1000 | 5 | Cardboard Tube |

Liability: Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.

