



# FCW FENI

*Rutile flux cored wire for cast iron*

## Classification

ISO 1071 : T C NiFeT3-CI M21

## Description & Applications

Rutile flux cored wire for gas shielded (Ar + CO<sub>2</sub>) arc welding of grey, malleable, nodular cast irons. Iron/Nickel welds deposit.

Also used for dissimilar weldments between cast irons and steels.

### Base material:

Lamellar cast iron	DIN 1691	GGG-40 à GGG-60
Malleable cast iron	DIN 1692	GTS 35 - GTS 65, GTW 35 - GTW 65
Nodular cast iron	DIN 1693	GGG40 - GGG70

## Typical Chemical Composition ( % )

	C	Si	Mn	Fe	Cu	Al	P	S	Ni
Min			3.0						45
Max	2.0	1.0	5.0	Rem.	2.5	1.0		0.03	60
Type	0.60	0.60	4.0	Rem.	0.01	0.01	0.010	0.015	45

## All Weld Metal Mechanical Properties

	R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	Hardness HB
Min				
Max				As welded
Type	340	550	16	160-200

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	180 - 280	20 - 28	12 - 25	ISO 14175 : M21 (Ar/CO <sub>2</sub> ) 10 - 20 l/min
	1.6	180 - 350	22 - 28	12 - 25	

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