



MIG FENI36

Classification

Without

Description & Applications

Solid wire filling a Ferro-Nickel alloy used for GMAW of alloys like Invar. Materials having a very low thermal expansion.

Main applications: Molds for composite, cladding of natural gas tanks.

Typical Chemical Composition (%)

	C	Si	Mn	Ni	P	S	Fe
Min							
Max				Not classified			
Type	0.01	0.10	0.30	36.0	0.010	0.010	Rem.

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	-	-	-	-
Max				
Type	300	400	28	-

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	70 - 180	18 - 26	ISO 14175: I1 (100% Ar) I3 (Ar+10-30%He) Z (Ar+He+H+CO ₂) 15-20 l/min
	1.0	80 - 220	18 - 28	
	1.2	150 - 320	22 - 32	
	1.6	220 - 380	24 - 34	

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