



## MIG FENI50

### Classification

Without

### Description & Applications

Solid wire for GMAW and reparation of nodular cast iron, either cold or after moderate heating. The deposit has a colour very similar to cast iron. Can be machined. MIG FeNi50 is also used for heterogeneous assembly of cast iron with steel.

#### Base materials

#### Cast iron

ASTM	DIN	NFA
A536 Grade 60-80	GGG-40 à GGG-60	FGS 400-12 à FGS 600-3
	GTS-35 à GTS-65	MN350-10 à MN650-3

### Typical Chemical Composition ( % )

	C	Si	Mn	Ni	P	S	Fe
Min							
Max				Not classified			
Type	0.03	0.60	0.70	55.0	0.015	0.010	Rem.

### All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	Hardness
Min	-	-	-	-
Max				
Type	320	550	25	As welded ~190HB

### 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 <sub>2</sub> ) 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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