



TIG FENI50

Classification

Without

Description & Applications

Solid rod for GTAW 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. TIG FeNi50 is also used for heterogeneous assembly of cast iron with steel.

Base materials

Nodular 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 | | | | Non classifié | | | |
| Type | 0.03 | 0.60 | 0.70 | 55.0 | 0.015 | 0.010 | 43.0 |

All Weld Metal Mechanical Properties

| | R _{p0.2} (MPa) | R _m (MPa) | A ₅ (%) |
|------|---------------------------|------------------------|----------------------|
| Min | - | - | - |
| Max | | | |
| Type | 290 | 320 | 10 |

Welding Current & Instructions

| Welding mode | Shielding Gas |
|--------------|--|
| TIG = - | ISO 14175: I1 (Ar) : 6-12 l/min Back shielding : I1 (Ar) : 3-6 l/min |

FT En-Ti21-170104

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