



TIG FENI60

Classification

ISO 1071 : S C NiFe-2

Description & Applications

Solid rod for GTAW and reparation of ferritic or martensitic spheroidal cast iron. Could be also used for heterogeneous assembly of nodular cast iron with steel or copper alloy or nickel alloy. Weld deposit characterized by good resistance against cracking and easily machinable.

Main applications: Cast iron pipe, flanges...

Typical Chemical Composition (%)

	C	Si	Mn	Ni	Cu	Al	Ti	P	S	Fe
Min			1.0	45						
Max	2.0	4.0	5.0	60	2.5	1.0	-	0.03	0.03	Rem.
Type	0.10	0.30	3.6	54.2	1.8	0.02	0.30	0.005	0.010	Rem.

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
Min	-	-	-	-
Max				
Type	300	500	25	As welded ~200HB

Welding Current & Instructions

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

Preheating of massive cast iron parts: 150-200°C. Interpass temperature: <120°C. Reduce the heat input to a minimum (low welding energy) to avoid cracks in base material.

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