Selectarc WELDING

FCW FENI50

Flux Cored Wire

Old reference FCW FeNi

Classification

EN ISO 1071 : T C Z NiFe1M

Characteristics

Flux cored wire to weld with shielding gas protection with a Ferro-Nickel alloy deposit for joining and repairing nodular cast iron. Deposit homogeneous and resistant against cracks. Particularly ecommended for dissimilar welding of cast iron to steels and cast iron constructions. Good bonding and flow of the weld metal.

Applications

Welding of defects in Foundries, Repairing of Engine blocks, Houses of tool machines, Gear boxes, Reducing parts, Pump bodies, Cast pieces, Valve bodies.

Base Materials

ASTM	DIN	NFA
A 48 class 25 B to 60 B	GG-15 to GG-40	FGL 150 to FGL 400
A 536 Gr. 60-80	GGG-40 to GGG-60	FGS 400-12 to FGS 600-3
	GTS -35 to GTS-65	MN 350-10 to MN 650-3

Typical Weld Metal Composition (%)

C	Si	Mn	Ni	Fe
0.80	0.60	4.00	45.00	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS Rm (MPa)	YS Rp0.2 (MPa)	% Elg A_5	Hardness (HB) AW
AW	500	340	16	170

Welding Current & Instructions

Welding Mode	Ø Wire (mm)	Welding Mode			Shieding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	ISO 14175
FCAW = +	1.2 1.6	80 - 210 90 - 240	17 - 24 22 - 28	12 - 25 19 - 27	M21 (Ar + 2 - 25 %Co_2) Ar + 1 - 3 %O_2 18 - 20 l/min

Welding Positions : 1G/PA ; 2G/PC ; 2F/PB