



# FCW FENI60

Flux cored wire for cast iron

## Classification

EN ISO 1071 : T C Z NiFe-1 M

## Description & Applications

Metal cored wire type Iron-Nickel for gas shielded (Ar + CO<sub>2</sub>) arc welding of grey, malleable and nodular cast irons. Particularly used for dissimilar weldments between cast irons and steels.

### Base material:

Lamellar cast iron	DIN 1691	GG 40 - GG 60
Malleable cast iron	DIN 1692	GTS 35 – GTS65, GTW 35 – GTW 65
Nodular cast iron	DIN 1693	GGG 40 – GGG70

## Typical Chemical Composition ( % )

C	Si	Mn	Ni	P	S	Fe
0.50	0.50	2.5	60.0	<0.015	<0.015	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	Hardness
350	470	15	180-200 HB

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	80 - 200	17 - 25	12 - 25	ISO 14175 : M21 (Ar + CO <sub>2</sub> ) 10-20 l/min
	1.6	90 - 250	18 - 27		

FT En-CI07-160321



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