



**A<sub>5</sub> FENI50**

**Classification**

Without

**Description & Applications**

Solid wire used in welding and reparation of cast iron, either cold or after moderate preheating. The colour of the deposit is similar to cast iron, the structure is different. Also used in assembly and surfacing of lamellar and nodular cast iron. MIG FeNi 50 is also used for heterogeneous assembly of cast iron with steel. Can be machined.

**Base material:**

**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	Fe	P	S
0.03	0.2	0.5	55.0	43.0	<0.015	<0.015

**All Weld Metal Mechanical Properties**

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )
320	550	25

**Welding Current & Instructions**

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	1.0	90-160	24-28	Ar + 2% CO <sub>2</sub>
	1.2	160-200	24-28	Ar/He + 0.05% CO <sub>2</sub>

Ind.10



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