



TIG FENI50

Old reference: TIG FeNi50

Classification

Without

Description & Applications

Solid rod for TIG welding 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
0.03	0.6	0.7	55.0	<0.015	<0.015	43.0

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
290	320	10

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon : 3-6 l/min

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