

Standards

DIN 8555	MF - NiFe 2
AWS A5.9	E NiFe-C1

Characteristics

Carbo F-NiFe 60/40 is a tubular wire which deposit an alloy of the Ferro-nickel type. It is suitable for joining and repairing all types of grey cast iron, also for joining cast iron with steel, but especially for nodular cast iron. The colour of the deposit is very similar to the base material and corrosion will be identical to the base material later on.

Typical applications

The physical property of the 60% nickel and 40% iron alloy makes it suitable for grey cast iron parts and spherical cast iron. The weld deposit contains approximately 60% Ni and 40% Fe. It is machinable. Used for joining and repairing nearly all types of cast iron.

Welding instructions

Thoroughly clean the surface of the work-piece. When welding on cast iron, heat input should be as low as possible (low amperage). To limit internal stress of the base metal, hammering of the beads is recommended after each pass.

Mechanical properties of all-weld metal (typical values)

Tensile strength R_m N/mm ²²	Yield strength $R_{p0,2}$ N/mm ²	Elongation A_5 %	Hardness HB
500	350	10	ca. 180

Weld metal analysis (typical, wt. %)

C	Si	Mn	Ni	Fe	Cu
<0,1	< 1	4,0	Rest	40,0	+

Gas types EN 439

I1, M13: Argon and 99% Argon with 1% oxygen

Current

= +

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
1,6	1/16	20 - 26	160 - 260	G
2,0	5/64	22 - 27	220 - 280	G
2,4	3/32	24 - 28	260 - 340	G
2,8	7/64	25 - 29	300 - 400	G

Delivering form

G = Flux cored wire for shielded arc welding

Coils, weight

B/BS 300 = 15 kg B 450 = 30 kg pay off pack = 150 / 300 kg

Rev. 001

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.