

Classifications

DIN 8573

(ca) MF NiFe-2-S

Characteristics and typical fields of application

FeNi alloy with 4% Manganese designed for joining and surfacing of cast iron pieces. Can also be used for dissimilar welding between cast iron and steel.

Microstructure: Austenite

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Field of use: Repair work on cast iron components.

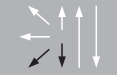
Typical analysis

	C	Si	Mn	Ni	Fe
wt.-%	0.7	0.6	1.8	bal.	44.0

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Hardness
	HB
u	160

Operating data

	Polarity	DC +	Dimension mm	Current A	Voltage V
	Shielding gas (EN ISO 14175)	M13: Argon 98% + Oxygen 2% / I1: Argon 100% / M21: Argon 82%+ CO2 18%	1.2	110-180	20-31
	Stick-Out	max. 20 mm			
	Gas-Rate (L/min)	12-15			

Approvals

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