

CLASSIFICATIONS

EN ISO 1071 : S C NiFe-1

DESCRIPTION

- WI NiFe-1 wire is used for joining and build-up of all types of cast irons (gray, tempered, sfero) and cast iron to non alloyed and high alloyed steels, copper and nickel based alloys
- Especially it is suitable for building up cast moulds in automotive industry and iron and steel sector
- Machinability is easy and weld metal surface must be clean and pre-heat at 150°C - 250°C
- Shielding gas: Ar (MIG and TIG)

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.05 | Cu: 0.35 | Mn: 0.60 | Fe: 44-46 | Ni: min.53

MECHANICAL PROPERTIES

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Hardness (HB)	Elongation (L ₀ =5d ₀) (%)
min. 290	min. 425	200	min. 8

WELDING POSITIONS



CURRENT TYPE

MIG D.C. (+) / TIG D.C.(-)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)	Package Weight (Kg)
1011100189	1.20 / 0,047"	15
1011100190	1.6 x 1000 / 1/16 x 39"	5
1011100191	2.0 x 1000 / 5/64 x 39"	5
1011100192	2.4 x 1000 / 3/32 x 39"	5