

E NiFe-CI (FN 55)

Nickel Alloy TIG/GTAW

Standards

EN/ISO-Standard - 1071
EN/ISO-Classification - SC NiFe-1

AWS-Standard - A5.15
AWS-Classification - E NiFe-CI

Features and Applications

- Ferro-nickel solid wire used for welding cast iron and ductile iron.
- Suitable for dissimilar joints between cast iron, mild steel, low alloy and stainless steels.
- Recommended for welding high sulphur, phosphorous or lubricant-contaminated castings.
- Typically used for a range of repair and fabrication applications, including rebuilding shafts, wheels, critical joints between steel and cast iron etc.
- **Test Certificates can be found online @wilkinsonstar247.com**



Typical Base Materials

Grey cast iron, malleable, nodular*
* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF

Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

Polarity

TIG DC (-)

Mechanical Properties

| Tensile Strength (N/mm ²) | Yield Strength (N/mm ²) | Elongation (%) | Impact Strength (J) |
|---------------------------------------|-------------------------------------|----------------|---------------------|
| 400 - 579 | - | - | - |

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

Chemical Composition of Weld Metal %

| C % | Mn % | Si % | P % | S % | Fe % | Ni % | Cu % | Al% |
|------|------|------|------|------|------|-------|------|------|
| max | max | max | max | max | rem. | 54.00 | max | max |
| 2.00 | 0.80 | 0.20 | 0.03 | 0.03 | | 56.00 | 2.50 | 1.00 |

Packaging Data

| Part No. | Diameter Ø (mm) | Package Length (mm) | Package Weight (Kg) | Package Type |
|------------|-----------------|---------------------|---------------------|----------------|
| 6011100614 | 1.60 | 1000 | 5 | Cardboard Tube |
| 6011100615 | 2.40 | 1000 | 5 | Cardboard Tube |
| 6011100616 | 3.20 | 1000 | 5 | Cardboard Tube |

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