

CARBOCAST NIFE

TOP FEATURES

- Suitable for cast irons with globular graphite (GJS), black-heart cast iron (GJMB), white-heart cast iron (GJMW), austenitic cast iron and dissimilar joints to steel.
- Weld at low heat input with short beads, ~10 to 30mm, and hammer peen.
- Weld metal can be machined.

TYPICAL APPLICATIONS

- Cast Iron
- Maintenance
- Repair

CLASSIFICATION

EN ISO 1071-A S NiFe1

SHIELDING GASES (ACC. EN ISO 14175)

I1 Inert gas Ar (100%)
 M12 Mixed gas Ar+ 0.5-5% CO₂
 M13 Mixed gas Ar+ 0.5-3% O₂

APPROVALS

DB	CE
+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	Ni	Cu	Fe	Al
0.9	0.8	0.7	55	1.0	42	0.5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C	Hardness (HB)
Typical values	M12	AW	≥290	≥400	≥20	≥80	150-200

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (BS300)	15.0	W000283707
	DRUM	250.0	W000400785

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.