

# 55NiFe

## TOP FEATURES

- Solid wire for MIG welding of cast iron

## CLASSIFICATION

EN ISO 1071-A S C NiFe-1

## SHIELDING GASES (ACC. EN ISO 14175)

I1	Inert gas Ar (100%)
M13	Ar+ 2% O <sub>2</sub>
M21	Mixed gas Ar+ 15-25% CO <sub>2</sub>
C1	Active gas 100% CO <sub>2</sub>

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

	C	Mn	Si	S	P	Ni	Fe	Cu	Co
Min.						52.0	bal.		
Max.	0.15	1.0	0.5	0.02	0.03	60.0	bal.	0.5	2.0
Typical	0.05	0.7	0.2	<0.01	<0.01	58	40	0.01	0.05

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Typical values as welded		MIG (Ar-5%CO <sub>2</sub> )
Tensile strength	(MPa)	400
0.2% Proof strength	(MPa)	230
Elongation (%)		24
Hardness	(HV)	150

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S300)	15.0	M55NIFE-12

## 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.  
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