

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% O₂
 M21 Mixed gas Ar+ 15-25% CO₂
 C1 Active gas 100% CO₂

CHEMICAL COMPOSITION (WEIGHT %), 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 ₂) |
|---------------------------|--------------------------------|
| 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.
 Please refer to www.lincolnelectric.eu for any updated information.