

CARBOCAST NiFe is an S C NiFe1 type solid MIG/MAG welding wire, supplied layer wound for welding of cast iron. Suitable for use with inert or with Ar-CO2 mixed gases.

CARBOCAST NiFe is used for dissimilar joining and surfacing of cast iron without or with only a minimum preheating of < 300°C, cast iron cold welding. Used for welding applications on new cast-iron components made of globular gray-cast iron (GJS/GGG) and dissimilar joining of GJS to steel. 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 pein. Weld metal can be machined.

Classification	Approvals	Grade
EN ISO 1071: S NiFe1	DB	●

Chemical analysis (Typical values in %)

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

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
				+20 °C	
As Welded	>290	>400	>20	>80	150-200 HB

Gas test: 98% Ar+2% CO2

Shielding Gas - EN ISO 14175 : I1, M12, M13

Materials

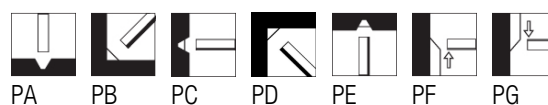
GJS-350 - GJS-700; GJMW-350-4 - GJMW-360-12; GJMB-300 - GJMB-700

Storage

Keep dry and avoid condensation.

Current condition and welding position

DC+



Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15
1.0	W000283706
1.2	W000283707