

## Classifications

DIN 8573

(ca) MF NiFe-2-S

## Characteristics

FeNi alloy with 4% Manganese designed for joining and surfacing of cast iron pieces. Can also be used for dissimilar welding between cast iron and steel.

Microstructure: Austenite

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 98% + Oxygen 2% or Argon 100% or Argon 82%+ CO<sub>2</sub> 18%

## Field of use

Repair work on cast iron components.

## Typical analysis in %

C	Mn	Si	Ni	Fe
0,25	3,5	0,7	balance	30,0

## Typical mechanical properties

Hardness as welded: 140 HB

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	110-180	20-31	20 max.	12-15