

55NiFe

MIG (GMAW)

SOLID MIG WIRE FOR WELDING CAST IRONS

PRODUCT DESCRIPTION

Solid wire for MIG welding.

CLASSIFICATIONS

ISO 1071 S C NiFe-1

ASME IX QUALIFICATION

QW432 F-No

CHEMICAL COMPOSITION (WIRE WT %)

	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

ALL-WELD MECHANICAL PROPERTIES

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

TYPICAL OPERATING PARAMETERS

	Shielding	Current	Diameter (mm)	Parameters
MIG	Ar / Ar + 1-2%O ₂ / Ar + 2-25%CO ₂ / 100%CO ₂	DC+	1.2	200A, 28V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.2	15	S300	M55NIFE-12

FUME DATA (WT % TYPICAL)

Fe	Mn	Cr3	Ni	Cu	OES (mg/m ³)
35	2	<0.1	30	<0.5	1.7