

# DT-NiFe

# Nickel Alloy MIG/MAG-Wire TIG – Rods

## Specifications

DIN EN ISO 1071      S C NiFe-1  
 BS: 2901              NA-47

## Application

NiFe-wire/rod for welding cast irons  
 (ductile, malleable and grey cast irons)

## Chemical Composition Element by weight (%)

C: 0,05    Cu : 0,35    Mn: 0.60    Fe: 44-46,0    Ni: mind. 53,0

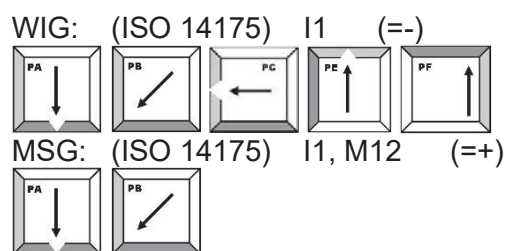
## Mechanical Properties (typical)

0,2%Elongation (Rp0,2)      300 N/mm<sup>2</sup>  
 Tensile Strength (Rm)      450 N/mm<sup>2</sup>  
 Elongation (A)(Lo=5do)      10%

## Approvals

MIG: DB

## Shielding gas/Polarity



## Typical Base Material

spheroidal graphite cast iron (GJS)  
 EN-GJS-350-22-LT bis EN-GJS700-2  
 (GGG35 bis GGG70)  
 GJS with X120Mn12 (1.3401)  
 Steel (1.2) with X120Mn12 (1.3401)

## Packaging

MIG/MAG: spools D 100 / D 200 / K 200 / K 300  
 TIG: 10-kg-boxes