

## AA FeNi

CATEGORY	FCAW Flux-Cored	
TYPE	Flux cored welding wire developed for welding cast iron with excellent weldability.	
APPLICATIONS	Joining and rebuilding Cast Iron with globular graphite, tempered Cast Iron and for joining Cast Iron with steel.	
PROPERTIES	Very good welding and wetting characteristics and high resistance to cracks and fissures. Extreme good deposition rate compare to MMA. High strength and good bonding weld metal..	
CLASSIFICATION	EN ISO	1071:T C Z NiFe-1 M
	DIN	8555: MSG NiFe-2

SUITABLE FOR	Joining and rebuilding Cast Iron with globular graphite, tempered Cast Iron and for joining Cast Iron with steel, Grey cast iron, malleable, nodular : NF A 32-101 : FGL 150, 200, 250, 300, 350, 400. NF A 32-201 : FGS 370-17, 400-12, 500-7, 600-3, 700-2. NF A 32-702 : MN 350-10, 380-18, 450-6, 350-4, 650-3. DIN 1691 : CG-14, 18, 25, 30. DIN 1693 : GGG-40, 50, 60, 70. DIN 1692 : GTS-35, 45, 55, 65, 70, X120Mn12, 1.3401
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APPROVALS	CE approved
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### WELDING POSITIONS:



### WELD METAL WEIGHT %

C	Mn	Si	Fe	Ni	FNW
0.70	4.50	0.60	34	rem	-

### MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW	340	550	16				165-190

AW = as welded

### WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		spool type	Packing	
	Voltage (V)	Current (A)		kg / spool	kg / pallet
1.2	19-26	80-180	S-300	15	1080
1.6	19-27	100-250	S-300	15	1080

REDRYING TEMPERATURE	150 °C / 24hr
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GAS ACC. EN ISO 14175:	I1
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