

## NiFe 60-40

<b>CATEGORY</b>	GMAW-GTAW Solid wires																																							
<b>TYPE</b>	Solid high nickel based wire for cast iron and dissimilar welding																																							
<b>APPLICATIONS</b>	Cast Iron repairs, rebuilding shafts, wheels, critical joints between steel and cast iron etc.																																							
<b>PROPERTIES</b>	Nickel Iron based filler metal for joint welding and claddings on cast Iron. Very well suited also for dissimilar welding between cast iron and high alloyed stainless and heat resistant steels or mild steels. Excellent Weldability with extreme crack resistance with a ductile weld deposit. Good welding and wetting characteristics and high resistance against porosity. Very well suitable for welding with robotics or automated processes.																																							
<b>CLASSIFICATION</b>	AWS	A 5.15: E NiFe-C1																																						
	EN ISO	1071: SC NiFe-1																																						
	DIN: W.Nr.	2.4560																																						
	DIN	NA																																						
<b>SUITABLE FOR</b>	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																																							
<b>APPROVALS</b>	DB (62.206.01) and CE approved																																							
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<b>REDRYING TEMPERATURE</b>	Not required																																							
<b>GAS ACC. EN ISO 14175:</b>	I1, M11, M12																																							