

## NILO FM CF36

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Filler metal with extreme low thermal expansion.

**APPLICATIONS** Welding applications that require the lowest thermal expansion to avoid solidification and reheat cracking.

**PROPERTIES** NILO FM 36 is used for welding NILO Alloy 36, Filler Metal CF 36 is formulated to have low thermal expansion characteristics similar to NILO Alloy 36, while providing freedom from solidification and reheat cracking. CF 36 is available for Tig, Mig and SAW process.

**CLASSIFICATION**

AWS	no class
EN ISO	no class
DIN	1736:

**SUITABLE FOR** Nilo alloy 36, Invar, cast Iron,

**APPROVALS** CE approved

**WELDING POSITIONS:**



C	Mn	Si	Cr	Ni	Mo	Fe	Nb
0,2	0,4			36		62	1,6

### 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 HRc / HV
				-20°C	-40°C	-60°C	
As welded		550	25				

### WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		Spool type	Packing	
	Voltage	Current (A)		kg / spool	kg / pallet
0,9			D-300	13,62	
1,2	29-33	200-270	D-300	13,62	

**REDRYING TEMPERATURE** Not required

**GAS ACC. EN ISO 14175:** I1 (Spray arc), I3 (Pulse- & Short arc)