

Technical data sheet

011121MBA

**Cored welding wire
CAST NICI-G****CLASSIFICATION**

EN ISO 1071: T C NiFeT3-CI M21

DESCRIPTION

- Metal cored wire for semi-automatic gas shielded arc welding.
- Designed for welding grey, malleable, nodular and phosphorus cast iron.
- Also used to for dissimilar weldments between cast iron and steel.
- Welding of highly restrained or thick-walled pieces
- Preheat is not necessary. Heat input is low which favors limited heat affected zone

APPLICATIONS

- Joining and repairing all types of cast iron

Examples

Lamellar grey cast irons EN-GJL-100 to EN-GJL-350
 Malleable cast irons EN-GJMB-350-10 to 650-2
 Nodular cast irons EN-GJS-400-15 to EN-GJS-800-2

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Ni	Fe
0.6	4	0.6	45	Bal.

TYPICAL ALL-WELD MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	Hardness [HB]
550	340	16	160 - 200

SHIELDING GAS

EN ISO 14175: M20 (Ar + 5 - 15% CO₂)
 M21 (Ar + 15 - 25% CO₂)
 M12 (Ar + 2-3% CO₂)

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow [l/min]
1.2	DC+	180 - 280	20 - 28	12 - 25	10 - 20
1.6	DC+	180 - 350	22 - 28	12 - 25	10 - 20

WELDING POSITIONS

EN ISO 6947: PA, PB
 ASME IX: 1G, 1F

PACKAGING

Diameter	1.2 mm	1.6 mm
Standard packaging	EN ISO 544 – ASME IIC SFA 5.2M: BS300 spools	
Weight	15 kg	

Other packaging and other diameters: please contact us