

Technical data sheet

011121MBA

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

EN ISO 1071: T C NiFeT3-CI NO
 ASME IIC SFA 5.15 / AWS A 5.15: ENiFeT3-CI

DESCRIPTION

- Flux cored wire for self-shielded arc welding
- Designed for welding grey, malleable, nodular and phosphorus cast iron.
- Also used 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
1.4	4,5	0.7	47	Balance

TYPICAL ALL-WELD MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	Hardness [HB]
560	400	15	150

OPERATING CONDITION

Current type	Stick-out	Recovery
DC+	30-40 mm	88%

WELDING POSITIONS

Flat, half up, half down

PACKAGING

Diameter	1.6 mm	2.0 mm	2.4 mm
Standard packaging	EN ISO 544 – ASME IIC SFA 5.2M: BS300 spools		
Weight	15 kg		

Other packaging and other diameters: please contact us