



ER NiFe-CI (FN 55)

Nickel Alloy WIRE/GTAW



Standards

EN/ISO-Standard - 1071
EN/ISO-Classification - SC NiFe-1

AWS-Standard - A5.15
AWS-Classification - ER NiFe-CI

Features and Applications

- Ferro-nickel solid wire used for welding cast iron and ductile iron.
- Suitable for dissimilar joints between cast iron, mild steel, low alloy and stainless steels.
- Recommended for welding high sulphur, phosphorous or lubricant-contaminated castings.
- Typically used for a range of repair and fabrication applications, including rebuilding shafts, wheels, critical joints between steel and cast iron etc.
- **Test Certificates can be found online @wilkinsonstar247.com**



Typical Base Materials

Grey cast iron, malleable, nodular*
* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF

Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

Polarity

DC (-)

Chemical Composition % (Range)

C %	Mn %	Si %	P %	S %	Fe %	Ni %	Cu %	Al%
max	max	max	max	max	rem.	54.00	max	max
2.00	0.80	0.20	0.03	0.03		56.00	2.50	1.00

Packaging Data

Part No.	Diameter Ø (mm)	Package Length (mm)	Package Weight (Kg)	Package Type
6011100614	1.60	1000	5	Cardboard Tube
6011100615	2.40	1000	5	Cardboard Tube
6011100616	3.20	1000	5	Cardboard Tube

Mechanical Properties

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)
400 - 579	-	-	-

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.