

Classifications				
DIN 8573				
MF NiFe-1-S				
Characteristics				
Ferro-Nickel alloy especially designed for rebuilding and anti-wear protective coating of cast iron parts.				
Microstructure:	Austenite			
Machinability:	Good			
Oxy-acetylene cutting:	Cannot be flame cut			
Deposit thickness:	Depends upon application and procedure used			
Shielding gas:	Argon 98 % + Oxygen 2% or Argon 100%			
Field of use				
Repair work on cast iron components.				
Typical analysis in %				
C	Mn	Si	Ni	Fe
1,1	1,8	0,4	balance	45,0
Typical mechanical properties				
Hardness as welded: 200 HB				
Recommended welding parameters				
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	110-180	20-31	20 max.	12-15
1,6	150-250	20-31	20 max.	15-18