

## Characteristics

FeNi alloy with 12% Manganese designed for joining and surfacing of cast iron pieces. Can also be used for dissimilar welding between cast iron and steel.

Microstructure: Austenitic

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% or Argon 82%+ CO<sub>2</sub> 18%

## Field of use

Repair and joining of cast iron parts, joining of steel flanges onto cast iron pipes.

## Typical analysis in %

C	Mn	Si	Ni	Fe
0,2	12,0	0,4	balance	48,0

## Typical mechanical properties

Hardness as welded: 145 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.	12-15