

## Characteristics

FeNi alloy with 10% Manganese designed for repairing and surfacing of cast iron pieces.

Microstructure: Austenitic

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon + CO<sub>2</sub> (8-18%)

## Field of use

Repair and surfacing of cast iron parts.

## Typical analysis in %

C	Mn	Si	Ni	Fe
0,25	10,0	0,7	balance	48,0

## Typical mechanical properties

Hardness as welded: 150 HB

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	140-200	23-28	20 max.	12-15
1,6	150-250	23-28	20 max.	15-18