



Characteristics and scope of application

- Filler metal for multi-layer and overlay welding primarily for repair work on cast iron
- Recommended for dissimilar welds of cast iron and mild steels

Standard designations

DIN EN ISO 1071	AWS 5.15	DIN Mat.-No.
S NiFe-1	ENiFe-CI	~ 2.4472

Typical chemical composition of filler metal

	C	Si	Mn	P	S	Fe	Ni	Cu
Mass %	0.05	0.1	0.8	< 0.01	< 0.01	Bal.	55	< 0.1

All weld metal properties (min. values at rt)

Heat treatment	Yield strength	Tensile strength	Elongation	Impact toughness	
	R _{p0.2}	R _m	A ₅	ISO-V	
as welded	290 MPa	420 MPa	6%		

Welding instructions

Polarity	Shielding gas acc. to DIN EN ISO 14175
DC / +	I1, M12
DC / -	I1, I3

Low heat input and preheating temperature according to fabrication guideslines of cast iron manufacturer, but not above 300°C. Interpass temperature approx. 50°C above preheating temperature.

Base materials

EN-GJL-250, EN-GJS-350-22

Packaging (tolerances acc. to DIN EN ISO 544)

Diameter (mm)		Kg
1.6 / 2.0 / 2.4 / 3.2	X 1000 mm	5 / 10
0.8 / 1.0 / 1.2	BS 300 spool	15
1.6 / 2.4 / 3.2	K 415 / K 435 spool	25

Approvals on request