



Characteristics and scope of application

- Filler metal for multi-layer and overlay welding for maintenance and repair work of spheroidal cast iron (ferritic and austenitic)
- Recommended for dissimilar welds of ductile cast iron and mild / high alloyed steels.

Standard designations

DIN EN ISO 1071	AWS	DIN Mat.-No.
S NiFe-2	-	~ 2.4472

Typical chemical composition of filler metal

	C	Si	Mn	Fe	Ni	Cu
Mass %	0.1	0.2	3.3	Bal.	55	2.0

All weld metal properties (min. values at rt)

Heat treatment	Yield strength	Tensile strength	Elongation	Impact toughness	
	Rp0.2	R _m	A ₅	ISO-V	
as welded	42 ksi	61 ksi	6%		

Welding instructions

Polarity	Shielding gas acc. to AWS A5.32
DC / +	SG-A, M12
DC / -	SG-A, SG-AHe
Low heat input and preheating temperature according to fabrication guidelines of cast iron manufacturer. but not above 572°F. Interpass temperature approx. 122°F above preheating temperature.	
Base materials	
EN-GJS-350-22, EN-GJS-400-15	

Packaging (tolerances acc. to AWS A5.02)

Diameter (in)		lbs/PU
1/16 - 1/8	X 36 in	11 / 22
0.035 – 0.045	BS 300 spool	33
0.06 – 1/8	K 415 / K 435 spool	55

Approvals on request