

SK FN-O

DIN 8573 : (ca) MF NiFe-1-S

DESCRIPTION

1

Ferro-Nickel open-arc wire especially designed to repair and join heavy parts made of cast iron.

SUITABLE FOR

2

Repair work on cast iron components.

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

	C	Mn	Si	Ni	Fe
All Weld	0.60	1.4	0.3	Bal.	45.0

TYPICAL MECHANICAL PROPERTIES

4

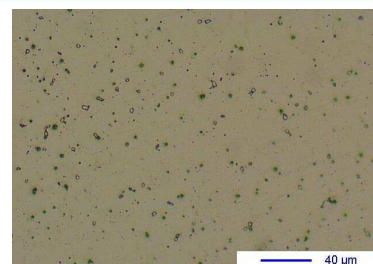
Hardness as welded

175 HB

GENERAL CHARACTERISTICS

5

- Microstructure: Austenite
- Machinability: Good
- Oxy-acetylene cutting: Cannot be flame cut
- Deposit thickness: Depends upon application and procedure used
- Metal cored



WELDING PARAMETERS & ECONOMICAL DATA

6

Diameter [mm]	Current [A]	Voltage [V]	Stick-Out	Article code	Packaging	Availability
1,6	180-200	26-30	35-40	29443	Spool 15 Kg	On request with minimal quantity
2,4	250-300	26-30	35-40	NA	Spool 15 Kg	On request with minimal quantity

The information about the products contained in the data sheets are based on intensive tests and careful investigations. However we can't assume any form of liability concerning the exactness of it. The information may be changed or updated without previous notice. The user is invited to test the product with regard to his own application and responsibility.