

**Standards**

TS 9463 EN ISO 1071 : S C NiFe-1
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**Chemical Composition of  
Welding Wire % (Typical)**

C	Cu	Mn	Fe	Ni
0.05	0.35	0.60	44-46	min.53

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Hardness (HB)	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))
min. 290	min. 425	200	min. 8

**Features and Applications**

- NiFe SG MIG-TIG wire is used for joining and build-up of all types of cast irons (gray, tempered, sfero) and cast iron to non alloyed and high alloyed steels, copper and nickel based alloys
- Especially it is suitable for building up cast moulds in automotive industry and iron and steel sector
- Machinability is easy and weld metal surface must be clean and pre-heat at 150°C - 250°C
- Shielding gas: Ar (MIG and TIG)

**Welding Positions**

**Welding Electrode**

GeKaTec Fe-CAST / GeKaTec Fe-CAST HD

**Current Type**

MIG D.C. (+) / TIG D.C.(-)

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)	Package Weight (Kg)
6031100308	1.20 / 0,047"	15
6031100309	1.6 x 1000 / 1/16 x 39"	5
6031100310	2.0 x 1000 / 5/64 x 39"	5
6031100311	2.4 x 1000 / 3/32 x 39"	5

Approvals: CE, SEPRO