

## IABCO FN55

### MIG/GMAW and TIG/GTAW wire for cast iron

Product name	IABCO FN55
Classification EN ISO	1071: S C NiFe-1
Material No.	-
Classification AWS	A5.15: ENiFe-CI Nearest no directly equivalent classification for solid wire.
Approvals	-
Applications	IABCO FN55 is a Ni-Fe wire used for welding cast iron and ductile iron. The wire is used for a range of repair and fabrication applications involving cast iron and ductile iron. The wire is also suitable for dissimilar joints between cast iron and mild, low alloy and stainless steels.
Base materials	For a wide range of spheroidal graphite (SG), nodular and ductile cast irons.
Typical analysis of wire, weight %	C: 0.1 Si: 0.2 Mn: 0.5 Ni: 55 Fe: Balance
Typical heat treatment <sup>(1)</sup>	Preheat: Often welded cold but preheat can be up to ~250°C depending on application and base material. Interpass temperature: Normally ~250°C. PWHT: Not normally required.
Mechanical properties of weld deposit <sup>(2)</sup>	0.2% proof stress, Rp0.2%: 400MPa. Tensile strength, Rm: 225MPa. Elongation, 4d/5d: 20%.
Other products	-

**Notes** (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.