



# Ni-Fe Solid MIG/TIG Wire

## Welding of Cast Iron

BS 2901 Pt5: NA 47  
ISO 1071 NiFe-1

### SW-55

#### DESCRIPTION & APPLICATION

MIG Filler Wire for the repair and reclamation of Cast Iron, particularly Spheroidal Graphite and Ductile Iron. Also suitable for the welding of Cast Iron to Mild and low Alloy Steels.

#### BASE MATERIALS

Cast Irons of the Flake Graphite, Spheroidal Graphite and Nodular type, such as GG and GGG.

#### MECHANICAL PROPERTIES

N/A	N/A	N/A	140-190
UTS n/mm	YIELD 0.2%	ELONG A5%	HARDNESS HV

#### METAL WELD COMPOSITION %

<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cu</b>	<b>Ni</b>	<b>Fe</b>
0.02	0.1	0.3	0.02	55.0	BAL

#### PACKAGING

15kg Spools (MIG)  
5kg Tubes (TIG)

#### DIAMETERS

1.0, 1.2, 1.6mm (MIG)  
1.6, 2.4mm (TIG)

#### WELDING INSTRUCTIONS

MIG & TIG Shielding Gas 5% CO<sub>2</sub> in Argon. Weld with Dip transfer where possible. Do not overheat base material. Fill all craters. TIG. Pure Argon.

**For more details on welding of Cast Iron, please see our Information Sheets.**  
**Visit:** [www.westbrookwelding.co.uk/downloads](http://www.westbrookwelding.co.uk/downloads)