

MIDALLOY ERNiFe-CI (FM55) BARE WIRE

CLASSIFICATION

- Currently there is no AWS classification for this product.

DESCRIPTION

- MIDALLOY ERNiFe-CI nickel alloy bare wire is used for GMAW and GTAW welding.

APPLICATIONS

- MIDALLOY ERNiFe-CI nickel alloy bare wire is used for GMAW and GTAW joining of various cast irons.
- This alloy can also be used for overlay, build-up, and repair, where welds do not have to be machined.
- This alloy can also be used for dissimilar-welding for applications such as cast irons to low-alloy or carbon steels.
- A preheat and inter-pass temperature of 350°F minimum is normally recommended during welding.

TYPICAL CHEMISTRY

C	Mn	Si	Fe	Ni + Co	P	S	Mo	Cu	Mg
.05	.25	.15	44.0	55.0	.001	.002	.02	.13	.01

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	89,500 PSI
YIELD STRENGTH	62,000 PSI
ELONGATION	35%

TYPICAL WELDING PARAMETERS FOR GMAW

SIZE	AMPERAGE	VOLTAGE	SHIELDING GAS
.035" GMAW	100-160	20-30	65%Ar-35%He @ 35-45 cfh
.045" GMAW	120-190	20-25	65%Ar-35%He @ 35-45 cfh

*Note: Argon or 75%Ar-25%He
Electrode stickout 1/2": gas cup 5/8" dia.

TYPICAL WELDING PARAMETERS FOR GTAW

AMPERAGE	VOLTAGE	SHIELDING GAS
60-220	12-20	Argon

STANDARD PACKAGING

- GTAW (TIG) 10 lb. Tube / 60 lb. Carton 1/16", 3/32", 1/8" Diameters
- GMAW (MIG) 30 lb. Spool - .035" and .045" Diameters

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