

## MC-Ni 55M (MIG)

WELDING POSITIONS :

**DESCRIPTION AND APPLICATIONS**

High strength Fe-Ni Alloy for welding of cast iron and for joining cast iron to steel. Also suitable for welding ductile iron of which strength is required.

**NOTES ON USAGE**

- 1) For GTAW process, use DC-EN, Pure Argon.
- 2) For GMAW process, Spray Transfer or Short Circuit Transfer mode can be used.
- 3) Pure Argon, 98% Argon +2% O<sub>2</sub> and 80% Argon + 20% O<sub>2</sub>.

WIRE ANALYSIS (Wt%)							
C	Si	Mn	P	S	Ni	Fe	Special Element
0.01	0.46	2.89	0.010	0.009	55.50	Bal	1.0-3.0

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES •			
YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
-	600 N/mm <sup>2</sup>	38%	-

• in "as welded" condition.

PRODUCT NAME	SIZE (mm)	PACKAGING (Kg)
MC-Ni55 (MIG)	1.2	12.5