



CEWELD Ni-Rod 44 Tig

TYPE Tig rods for cast iron welding

APPLICATIONS Ductile, grey and malleable Cast Iron and Cast Steel repairs, rebuilding wornout parts and also suitable for joining steel t cast Iron.

PROPERTIES Very low thermal expansion therefore good crack resistance in the weldmetal

CLASSIFICATION AWS A 5.15: E NiFeMn-CI
EN ISO 1071: NiFeMn-CI

SUITABLE FOR Cast iron, Cast steel

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	S	Ni	Cu	Al
0.25	0.15	11.9	0.002	42	0.04	0.003

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded		690	35	190 HB

REDRYING Not required

GAS ACC. EN ISO 14175 I1