

CEWELD NiFe 44Mn (NI-ROD)

TYPE Solid Nickel-Iron-Manganese welding wire for cast iron.

APPLICATIONS Ductile, gray and malleable Cast Iron and cast steel repairs, rebuilding wornout parts and also suitable for joining steel to cast Iron.

PROPERTIES Excellent wetting properties that enable this welding wire to weld with high welding speed due to the high manganese content. Thermal expansion is very low (close to NILO) and the weld deposit is extremely crack resistant.

CLASSIFICATION AWS
EN ISO 1071: NiFeMn-CI

SUITABLE FOR Grey cast iron, malleable, nodular : NF A 32-101 : FGL 150, 200, 250, 300, 350, 400. NF A 32-201 : FGS 370-17, 400-12, 500-7, 600-3, 700-2. NF A 32-702 : MN 350-10, 380-18, 450-6, 350-4, 650-3. DIN 1691 : CG-14, 18, 25, 30. DIN 1693 : GGG-40, 50, 60, 70. DIN 1692 : GTS-35, 45, 55, 65, 70.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

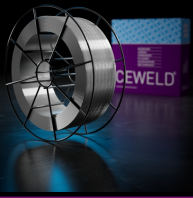
Ni	Mn	Si	C	Fe
44	12	0.08	1.5	Rem.

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, M21



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NIFE 44MN (NI-ROD) 1,2MM

Packaging	KG/unit	EanCode
BS-300	13,60	8720663420671