



CEWELD NiFe 55

TYPE Nickel iron MIG wire for joining dissimilar materials and cast iron.

APPLICATIONS Suitable for welding stainless steels containing 12-14 Cr. Also for welding mild and low alloy steels which are exposed to temperatures up to 450C. Cast Iron repairs, rebuilding shafts, wheels, critical joints between steel and cast iron etc.

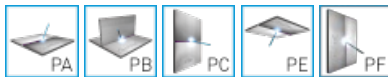
PROPERTIES Nickel Iron based filler metal for joint welding and claddings on cast Iron. Very well suited also for dissimilar welding between cast iron and high alloyed stainless and heat resistant steels or mild steels. Excellent Weldability with extreme crack resistance with a ductile weld deposit. Good welding and wetting characteristics and high resistance against porosity. The weld metal is corrosion and heat resistant. Very well suitable for welding with robotics or automated processes.

CLASSIFICATION AWS A 5.15: E NiFe-CI
EN ISO 1071: SC NiFe-1
W.Nr. 2.4472

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 (%)

C	Si	Mn	P	S	Ni	Fe	Cu
0.015	0.06	0.65	0.003	0.001	55	Rem.	0.01

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded	350	480	12	195 HB

REDRYING Not required

GAS ACC. EN ISO 14175 I1