



CEWELD Ni-Rod 44

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

APPLICATIONS Ductile, grey 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 extreme crack resistant.

CLASSIFICATION AWS A 5.15: E NiFeMn-CI
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 WELD METAL (%)

C	Si	Mn	Ni	Al	Fe
0.25	0.08	12	42	0.3	Rem.

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded		690	35	190 HB

REDRYING Not required

GAS ACC. EN ISO 14175 11