



# CEWELD Ni-Rod 44 Tig

<b>TYPE</b>	Tig rods for cast iron welding	
<b>APPLICATIONS</b>	Ductile, grey and malleable Cast Iron and Cast Steel repairs, rebuilding wornout parts and also suitable for joining steel t cast Iron.	
<b>PROPRIÉTÉS</b>	Very low thermal expansion therefore good crack resistance in the weldmetal	
<b>CLASSIFICATION</b>	AWS EN ISO	A 5.15: E NiFeMn-CI 1071: NiFeMn-CI
<b>CONVIENT POUR</b>	Cast iron, Cast steel	

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



**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

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Hardness
As Welded		690	35	190 HB

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175** I1