



CEWELD Ni-Rod 44

TYPE	Solid Nickel-Iron-Manganese welding wire for cast iron					
TOEPASSINGEN	Ductile, gray and malleable Cast Iron and cast steel repairs, rebuilding wornout parts and also suitable for joining steel to cast Iron.					
EIGENSCHAPPEN	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.					
CLASSIFICATIE	AWS EN ISO	A 5.15: E NiFeMn-CI 1071: NiFeMn-CI				
GESCHIKT VOOR	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.					
GOEDKEURINGEN						
LASPOSITIES	   					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Ni	Al	Fe
	0.25	0.08	12	42	0.3	Rem.
MECHANISCHE WAARDEN	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	
	As Welded		690	35	190 HB	
HERDROGEN	Not required					
GAS ACC. EN ISO 14175	I1					