



CEWELD NiFe 60-40

TYPE	Welding wire for cast iron and dissimilar welding.								
APPLICATIONS	CEWELD® NiFe 60-40 is ideal for welding mixed joints, for example, cast iron, high-alloy, stainless, and heat-resistant steels, as well as structural steels. It is also ideal for thick-walled workpieces and steels with low carbon content. Examples include housings for pumps and valves, frames, and machining errors on castings, crushers, and gearboxes.								
PROPERTIES	CEWELD® NiFe 60-40 (~60% Ni, ~40% Fe) is a nickel-iron-based welding consumable. It has excellent weldability with extreme crack resistance and ductile weld metal. The color of the weld metal alloy is similar to that of the base material and corrodes in the same way. It has good welding and wetting properties as well as high resistance to porosity. It is very well suited for welding with robots or automated processes.								
CLASSIFICATION	AWS EN ISO W.Nr.	A 5.15: ER NiFe-CI 1071: SC NiFe-1 2.4560							
SUITABLE FOR	GG, GGG Spheroidal Cast Iron, Diluted Cast Iron, old Cast Iron, Steel to Cast Iron etc. Lamellar grey cast irons EN-GJL-100 to EN-GJL-350 Malleable cast irons EN-GJMB-350-10 to 650-2 Nodular cast irons EN-GJS-400-15 to EN-GJS-800-2 EN 1561: EN-GJL-100, EN-GJL-150, EN-GJL-200, EN-GJL-250, EN-GJL-300, EN-GJL-350, GG10, GG15; GG20, GG25; GG30; GG35; GG40 EN 1562: EN-GJMB-350, EN-GJMB-550 , EN- GJMW-350, EN- GJMW-550 , GTS 35, GTS 55, GTW 35, GTW 55 EN1563: EN-GJS-400-15, EN-GJS-400-18, EN-GJS-450-10, EN-GJS-500-7, EN-GJS-600-3, EN-GJS-700-2. GGG40, GGG45, GGG50, GGG60; GGG70, GGG80 X120Mn12, 1.3401								
APPROVALS	CE, DB: (62.206.01)								
WELDING POSITIONS	 PA  PB  PC								
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Ni	Fe	Cu	Al
	0.05	0.15	0.8	0.001	0.001	58	Rem.	0.03	0.07
MECHANICAL PROPERTIES	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)		A ₅ (%)	Hardness		
	As Welded		200	400		16	185 HB		
REDRYING	Not required								
GAS ACC. EN ISO 14175	I1, M11, M12								



CEWELD NiFe 60-40

NIFE 60-40 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663420725
Drum	250	8720663420749

NIFE 60-40 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663420732