



CEWELD NiFe 44Mn (NI-ROD)

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 extremely crack resistant.				
CLASSIFICATIE	AWS EN ISO W.Nr.	A 5.15: ER NiFeMn-CI 1071: SC NiFeMn-CI UNS N02216			
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 THE FILLER METAL (%)	Ni 44	Mn 12	Si 0.08	C 0.5	Fe Rem.
MECHANISCHE WAARDEN	Heat Treatment As Welded	R _{P0,2} (MPa) 350	R _m (MPa) 590	A5 (%) 35	Hardness 190 HB
HERDROGEN	Not required				
GAS ACC. EN ISO 14175	I1, M21				



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NIFE 44MN (NI-ROD) 1,2MM

Packaging	KG/unit	EanCode
BS-300	13,60	8720663420671