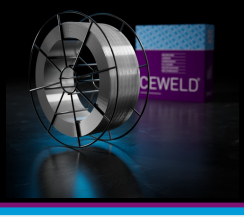

CEWELD Ni-Rod 44

certilas® THE FILLER METAL SPECIALIST

TYPE	Solid Nickel-Iron-Manganese welding wire for cast iron
ANWENDUNGEN	Ductile, gray and malleable Cast Iron and cast steel repairs, rebuilding wornout parts and also suitable for joining steel to cast Iron.
EIGENSCHAFTEN	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.
KLASSIFIKATION	AWS A 5.15: E NiFeMn-CI EN ISO 1071: NiFeMn-CI
GEEIGNET FÜR	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.
ZULASSUNGEN	
SCHWEISSPOSITIONEN	

TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

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

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded		690	35	190 HB

RÜCKTROCKNUNG	Not required
GAS ACC. EN ISO 14175	I1