



CEWELD Ni-Rod 44

TYPE	Solid Nickel-Iron-Manganese welding wire for cast iron					
APPLICATIONS	Ductile, gray and malleable Cast Iron and cast steel repairs, rebuilding wornout parts and also suitable for joining steel to cast Iron.					
PROPRIÉTÉS	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.					
CLASSIFICATION	AWS EN ISO	A 5.15: E NiFeMn-CI 1071: NiFeMn-CI				
CONVIENT POUR	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.					
AGRÉMENTS						
POSITIONS DE SOUDAGE	   					
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	Ni	Al	Fe
	0.25	0.08	12	42	0.3	Rem.
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	
	As Welded		690	35	190 HB	
ETUVAGE	Not required					
GAS ACC. EN ISO 14175	I1					