



CEWELD NiFe 55

TYPE	Nickel iron MIG wire for joining dissimilar materials and cast iron.							
TOEPASSINGEN	Suitable for welding stainless steels containing 12-14 Cr. Also for welding mild and low alloy steels which are exposed to temperatures up to 450C. Cast Iron repairs, rebuilding shafts, wheels, critical joints between steel and cast iron etc.							
EIGENSCHAPPEN	Nickel Iron based filler metal for joint welding and claddings on cast Iron. Very wel suited also for dissimilar welding between cast iron and high alloyed stainless and heat resistant steels or mild steels. Excellent Weldability with extreme crack resistance with a ductile weld deposit. Good welding and wetting characteristics and high resistance against porosity. The weld metal is corrosion and heat resistant. Very well suitable for welding with robotics or automated processes.							
CLASSIFICATIE	AWS EN ISO W.Nr.	A 5.15: E NiFe-CI 1071: SC NiFe-1 2.4472						
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	 PA  PB  PC  PE  PF							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Ni	Fe	Cu
	0.015	0.06	0.65	0.003	0.001	55	Rem.	0.01
MECHANISCHE WAARDEN	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)		A5 (%)	Hardness	
	As Welded		350	480		12	195 HB	
HERDROGEN	Not required							
GAS ACC. EN ISO 14175	I1							