CEWELD AA NiFe36

certilas® THE FILLER METAL SPECIALIST

TYPE

Flux cored welding wire developed for welding cast iron with excellent weldability.

TOEPASSINGEN

Joining and rebuilding Cast Iron with globular graphite, tempered Cast Iron and for joining Cast Iron with steel. Used for standards of length, measuring devices, laser components, bi-metal thermostat strip, thermostat rods, and tanks and piping for storing and transporting liquefied gases.

EIGENSCHAPPEN

Very good welding and wetting characteristics and high resistance to cracks and fissures. Extreme good deposition rate compare to MMA. High strength and good bonding weld metal. NiFe36 has a composition that matches "NiLo'" and offer the lowest schrinkage possible to avoid cracks during heating and the cooling period. The weld deposit also retains good strength and toughness at cryogenic temperatures and has a low coefficient of expansion from cryogenic temperatures to about 500°F (260°C).

CLASSIFICATIE

AWS	A 5.15: E NiFe-CI
EN ISO	1071: T C NiFe-1
W.Nr.	1.3912

GESCHIKT VOOR

Spheroidal Cast Iron, Diluted Cast Iron, old Cast Iron, Steel to Cast Iron etc.
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

GOEDKEURINGEN

LASPOSITIES

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Ni	Fe
0.1	0.5	2.4	36	Rem.

MECHANISCHE WAARDEN

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				150 HV

HERDROGEN

Not required

GAS ACC. EN ISO 14175

I1, M13