



CEWELD NiFe 55

TYPE	Nickel iron MIG wire for joining dissimilar materials and cast iron.							
ANWENDUNGEN	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.							
EIGENSCHAFTEN	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.							
KLASSIFIKATION	AWS EN ISO W.Nr.	A 5.15: E NiFe-CI 1071: SC NiFe-1 2.4472						
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 FÜLLMETALLS (%)	C	Si	Mn	P	S	Ni	Fe	Cu
	0.015	0.06	0.65	0.003	0.001	55	Rem.	0.01
MECHANISCHE GÜTEWERTE	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness		
	As Welded		350	480	12	195 HB		
RÜCKTROCKNUNG	Not required							
GAS ACC. EN ISO 14175	I1							