

CEWELD NiFe 44Mn (NI-ROD)

TYPE Solid Nickel-Iron-Manganese welding wire for cast iron.

APPLICATIONS CEWELD NiFe 44Mn (NI-ROD) is designed for automatic and semi-automatic welding of ductile, grey and malleable cast iron and steel repairs, rebuilding of worn parts and also for joining steel to cast iron.

PROPERTIES CEWELD NiFe 44Mn (NI-ROD) is a solid nickel-iron-manganese wire with excellent welding properties, which due to the high manganese content, allows high welding speeds. It can weld in all positions. Thermal expansion is very low (close to NILO) and the weld deposit is extremely crack resistant.
Pre and PWHT are not normally required but may be advantageous for heavy section, fully restrained joints in low ductility castings.

CLASSIFICATION

AWS	A 5.15: ER NiFeMn-CI
EN ISO	1071: SC NiFeMn-CI
W.Nr.	UNS N02216

SUITABLE FOR 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.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

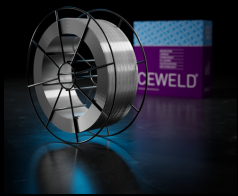
Ni	Mn	Si	C	Fe
44	12	0.08	0.5	Rem.

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded	350	590	35	190 HB

REDRYING Not required

GAS ACC. EN ISO 14175 I1, M21



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NIFE 44MN (NI-ROD) 1,2MM

Packaging	KG/unit	EanCode
BS-300	13,60	8720663420671