



# CEWELD NiFe 44Mn (NI-ROD)

|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                          |                                |                 |                    |
|------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------|--------------------------------|-----------------|--------------------|
| 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 extremely crack resistant.                                                                                                                                                                                                                                                                                                |                                                          |                                |                 |                    |
| CLASSIFICATION                                       | AWS<br>EN ISO<br>W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | A 5.15: ER NiFeMn-CI<br>1071: SC NiFeMn-CI<br>UNS N02216 |                                |                 |                    |
| 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                                 | <div>PAPBPCPDPEPF</div> |                                                          |                                |                 |                    |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | Ni<br>44                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Mn<br>12                                                 | Si<br>0.08                     | C<br>0.5        | Fe<br>Rem.         |
| PROPRIÉTÉS MÉCANIQUES                                | Heat<br>Treatment<br>As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | R <sub>P0,2</sub><br>(MPa)<br>350                        | R <sub>m</sub><br>(MPa)<br>590 | A5<br>(%)<br>35 | Hardness<br>190 HB |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                          |                                |                 |                    |
| GAS ACC. EN ISO 14175                                | I1, M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                          |                                |                 |                    |



# CEWELD NiFe 44Mn (NI-ROD)

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

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