

CEWELD NiFe 44Mn (NI-ROD)

TYPE	Solid Nickel-Iron-Manganese welding wire for cast iron.
ANWENDUNGEN	Ductile, gray and malleable Cast Iron and cast steel repairs, rebuilding wornout parts and also suitable for joining steel to cast Iron.
EIGENSCHAFTEN	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.
KLASSIFIKATION	AWS EN ISO 1071: NiFeMn-CI
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



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

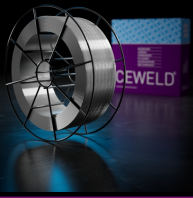
Ni	Mn	Si	C	Fe
44	12	0.08	1.5	Rem.

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded		690	35	190 HB

RÜCKTROCKNUNG 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