



# CEWELD NiFe 55 Tig

**TYPE** Nickel iron TIG wire for joining dissimilar materials and cast iron

**APPLICATIONS** Cast Iron repairs, rebuilding shafts, wheels, critical joints between steel and cast iron etc.

**PROPERTIES** Nickel Iron based filler metal for joint welding and claddings on cast Iron. Very well 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.

**CLASSIFICATION**

AWS	A 5.15: E NiFe-CI
EN ISO	1071: SC NiFe-1
W.Nr.	2.4472

**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 (%)**

C	Si	Mn	P	S	Ni	Fe	Cu
0.01	0.13	0.7	0.005	0.001	55	Rem.	0.03

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	300	450	8	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1



# CEWELD NiFe 55 Tig

NIFE 55 TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663424181

  

NIFE 55 TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663420756
	Tube	5	8720663417817

  

NIFE 55 TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663420763