



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.

PROPRIÉTÉS 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 |

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



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 |

PROPRIÉTÉS MÉCANIQUES

| Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded | 300 | 450 | 8 | HRc |

ETUVAGE 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 |