



# CEWELD Ni-Rod 44

<b>TYPE</b>	Solid Nickel-Iron-Manganese welding wire for cast iron
<b>APPLICATIONS</b>	Ductile, gray and malleable Cast Iron and cast steel repairs, rebuilding wornout parts and also suitable for joining steel to cast Iron.
<b>PROPRIÉTÉS</b>	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 extreme crack resistant.
<b>CLASSIFICATION</b>	AWS A 5.15: E NiFeMn-CI EN ISO 1071: NiFeMn-CI
<b>CONVIENT POUR</b>	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 WELD METAL (%)**

C	Si	Mn	Ni	Al	Fe
0.25	0.08	12	42	0.3	Rem.

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Hardness
As Welded		690	35	190 HB

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175** I1