



CEWELD NiFe 55 Tig

TYPE	Nickel iron TIG wire for joining dissimilar materials and cast iron							
ANWENDUNGEN	Cast Iron repairs, rebuilding shafts, wheels, critical joints between steel and cast iron etc.							
EIGENSCHAFTEN	Nickel Iron based filler metal for joint welding and claddings on cast Iron. Very wel 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.							
KLASSIFIKATION	AWS EN ISO W.Nr.	A 5.15: E NiFe-CI 1071: S C NiFe-2 2.4472						
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								
TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)	C	Si	Mn	P	S	Ni	Fe	Cu
	0.01	0.13	0.7	0.005	0.001	55	Rem.	0.03
MECHANISCHE GÜTEWERTE	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness		
	As Welded		300	450	8	HRc		
RÜCKTROCKNUNG	Not required							
GAS ACC. EN ISO 14175	I1							



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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