



CEWELD Ni-Rod 44

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 extreme crack resistant.					
KLASSIFIKATION	AWS EN ISO	A 5.15: E NiFeMn-Cl 1071: NiFeMn-Cl				
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 SCHWEISSMETALLS (%)	C	Si	Mn	Ni	Al	Fe
	0.25	0.08	12	42	0.3	Rem.
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	
	As Welded		690	35	190 HB	
RÜCKTROCKNUNG	Not required					
GAS ACC. EN ISO 14175	I1					