



# CEWELD AA NiFe 60-40

TYPE	Nickel-Ferro type Cored wire developed for welding cast iron with excellent weldability . (Type NiFe-2, NiFe-Cl)											
ANWENDUNGEN	<p>The weld deposit from <b>CEWELD ® AA NiFe 60/40</b> contains approximately 60% Ni and 40% Fe. It is machinable. Used for joining and repairing nearly all types of cast iron. Welding wire for GG, GGG joint and spot welding. Welding of highly restrained or thick-walled pieces.</p> <p>Casings for pumps and valves, frames, machining errors on castings, crushers, gear housing etc.</p>											
EIGENSCHAFTEN	<p><b>CEWELD ® AA NiFe 60/40</b> is a high nickel and iron alloyed cored wire for cold welding of all types of gray cast iron, also in combination with steel. In particular, however, for the welding of nodular cast iron. The alloy of the weld metal is very similar in color to the base material and corrodes like it later on. The alloy has excellent crack resistance and high strength and is also suitable for multi-layer welding. The weld seam can even be machined at the transition zones</p>											
KLASSIFIKATION	<p>AWS A 5.15: E NiFe-Cl EN ISO 1071: T-NiFe-2</p>											
GEEIGNET FÜR	<p><b>GG, GGG Spheroidal Cast Iron, Diluted Cast Iron, old Cast Iron, Steel to Cast Iron etc.</b> <b>Lamellar grey cast irons</b> EN-GJL-100 to EN-GJL-350 <b>Malleable cast irons</b> EN-GJMB-350-10 to 650-2 <b>Nodular cast irons</b> EN-GJS-400-15 to EN-GJS-800-2 EN 1561: EN-GJL-100, EN-GJL-150, EN-GJL-200, EN-GJL-250, EN-GJL-300, EN-GJL-350, GG10, GG15; GG20, GG25; GG30; GG35; GG40 EN 1562: EN-GJMB-350, EN-GJMB-550 , EN- GJMW-350, EN- GJMW-550 , GTS 35, GTS 55, GTW 35, GTW 55 EN1563: EN-GJS-400-15, EN-GJS-400-18, EN-GJS-450-10, EN-GJS-500-7, EN-GJS-600-3, EN-GJS-700-2. GGG40, GGG45, GGG50, GGG60; GGG70, GGG80</p>											
ZULASSUNGEN												
SCHWEISSPOSITIONEN												
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	P	S	Ni	Fe	Cu	Al			
	0.6	0.8	4	0.02	0.02	58	Rem.	0.3	0.05			
MECHANISCHE GÜTEWERTE	Heat Treatment			R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Hardness					
	As Welded			350	470	15	190 HB					
RÜCKTROCKNUNG	Not required											
GAS ACC. EN ISO 14175	M13, M21, M12											