

# CEWELD AA FeNi

**TYPE** Cored welding wire developed for welding cast iron with excellent weldability.(Type NiFe-2, NiFe-Cl)

**APPLICATIONS** **CEWELD ® AA FeNi** is for Joining and repairing all types of cast iron.  
Joining and rebuilding Cast Iron with globular graphite, tempered Cast Iron and for joining Cast Iron with steel. Joining and rebuilding Cast Iron with globular graphite, tempered Cast Iron. Grey cast iron, malleable, nodular

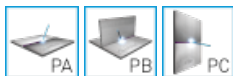
**PROPERTIES** **CEWELD ® AA FeNi** have a very good welding and wetting characteristics and high resistance to cracks and fissures. Extreme good deposition rate compare to MMA. High strength and good bonding weld metal.Designed for welding grey, malleable, nodular and phosphorus cast iron. Preheat is not necessary. Heat input is low which favors limited heat affected zone.

**CLASSIFICATION** EN ISO 1071: T C NiFeT3-Cl  
DIN 8555: MF 23-GF-150-G

**SUITABLE FOR** **GG, GGG Spheroidal Cast Iron, Diluted Cast Iron, old Cast Iron, Steel to Cast Iron etc.**  
**Lamellar grey cast irons** EN-GJL-100 to EN-GJL-350  
**Malleable cast irons** EN-GJMB-350-10 to 650-2  
**Nodular cast irons** 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

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

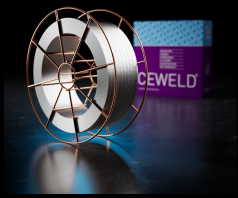
| C   | Si  | Mn | Ni | Fe   |
|-----|-----|----|----|------|
| 0.7 | 0.6 | 4  | 45 | Rem. |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      | 340                     | 550                  | 16                 | 180 HB   |

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21, M12, M20



# CEWELD AA FeNi

AA FENI 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663420824 |