



CEWELD NiFe 60-40

TYPE	Welding wire for cast iron and dissimilar welding.																										
APPLICATIONS	Cast Iron repairs, rebuilding shafts, wheels, critical joints between steel and cast iron etc.																										
PROPERTIES	CEWELD NiFe 60-40 is a Nickel Iron based filler metal for joint welding and claddings on cast Iron. Very well 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. Very well suitable for welding with robotics or automated processes.																										
CLASSIFICATION	AWS A 5.15: ER NiFe-CI EN ISO 1071: SC NiFe-1																										
SUITABLE FOR	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, X120Mn12, 1.3401																										
APPROVALS	CE, DB: (62.206.01)																										
WELDING POSITIONS																											
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table><tr><td>C</td><td>Si</td><td>Mn</td><td>P</td><td>S</td><td>Ni</td><td>Fe</td><td>Cu</td><td>Al</td></tr><tr><td>0.05</td><td>0.15</td><td>0.8</td><td>0.001</td><td>0.001</td><td>58</td><td>Rem.</td><td>0.03</td><td>0.07</td></tr></table>									C	Si	Mn	P	S	Ni	Fe	Cu	Al	0.05	0.15	0.8	0.001	0.001	58	Rem.	0.03	0.07
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MECHANICAL PROPERTIES	<table><thead><tr><th>Heat Treatment</th><th>$R_{P0,2}$ (MPa)</th><th>Rm (MPa)</th><th>A5 (%)</th><th>Hardness</th></tr></thead><tbody><tr><td>As Welded</td><td>350</td><td>450</td><td>16</td><td>185 HB</td></tr></tbody></table>									Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness	As Welded	350	450	16	185 HB								
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As Welded	350	450	16	185 HB																							
REDRYING	Not required																										
GAS ACC. EN ISO 14175	I1, M11, M12																										



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NIFE 60-40 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663420725
Drum	250	8720663420749

NIFE 60-40 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663420732