


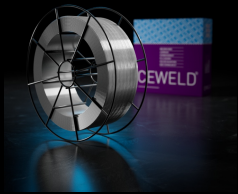


CEWELD NiFe 60-40

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 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. Very well suitable for welding with robotics or automated processes.								
CLASSIFICATION	AWS EN ISO		A 5.15: ER NiFe-CI 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	<div>  </div>								
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	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
MECHANICAL PROPERTIES	Heat Treatment		R _{P0,2} (MPa)		R _m (MPa)		A5 (%)	Hardness	
	As Welded		350		450		16	185 HB	
REDRYING	Not required								
GAS ACC. EN ISO 14175	I1, M11, M12								



CEWELD NiFe 60-40

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