



# CEWELD NiFe 55

TYPE	Nickel iron MIG wire for joining multiple pass welding cast iron. (NiFe-1, 2.4472)										
APPLICATIONS	CEWELD® NiFe 55 is suitable for welding mild and low alloy steels which are exposed to temperatures up to 450C. Multiple pass welding of spheroidal graphite cast irons and neutral tempered (black) malleable cast irons. Cast Iron repairs, rebuilding shafts, wheels, critical joints between steel and cast iron etc.										
PROPERTIES	CEWELD® NiFe 55 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. The weld metal is corrosion and heat resistant. Very well suitable for welding with robotics or automated processes.										
CLASSIFICATION	AWS A 5.15: E NiFe-Cl EN ISO 1071: SC NiFe-1 W.Nr. 2.4472										
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.										
APPROVALS											
WELDING POSITIONS											
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Ni	Fe	Cu			
	0.015	0.06	0.65	0.003	0.001	55	Rem.	0.01			
MECHANICAL PROPERTIES	Heat Treatment		R <sub>P0,2</sub> (MPa)	Rm (MPa)	A5 (%)	Hardness					
	As Welded		350	480	12	195 HB					
REDRYING	Not required										
GAS ACC. EN ISO 14175	I1										