



CEWELD NiFe 55 Tig

TYPE	Nickel iron welding rod for joining multiple pass welding cast iron. (NiFe-2, 2.4472)																	
APPLICATIONS	CEWELD® NiFe 55 Tig 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 Tig 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: S C NiFe-2 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										
	0.01	0.13	0.7	0.005	0.001	55	Rem.	0.03										
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>300</td><td>450</td><td>8</td><td>HRc</td></tr></tbody></table>								Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness	As Welded	300	450	8	HRc
Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness														
As Welded	300	450	8	HRc														
REDRYING	Not required																	
GAS ACC. EN ISO 14175	I1																	



CEWELD NiFe 55 Tig

NIFE 55 TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663424181

NIFE 55 TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663420756
Tube	5	8720663417817

NIFE 55 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663420763