



CEWELD NiFe 44Mn (NI-ROD)

TYPE	Solid Nickel-Iron-Manganese welding wire for cast iron.				
APPLICATIONS	Ductile, gray and malleable Cast Iron and cast steel repairs, rebuilding wornout parts and also suitable for joining steel to cast Iron.				
PROPRIÉTÉS	Excellent wetting properties that enable this welding wire to weld with high welding speed due to the high manganese content. Thermal expansion is very low (close to NILO) and the weld deposit is extremely crack resistant.				
CLASSIFICATION	AWS EN ISO W.Nr.	A 5.15: ER NiFeMn-CI 1071: SC NiFeMn-CI UNS N02216			
CONVIENT POUR	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.				
AGRÉMENTS					
POSITIONS DE SOUDAGE	PAPBPCPDPEPF				
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	Ni 44	Mn 12	Si 0.08	C 0.5	Fe Rem.
PROPRIÉTÉS MÉCANIQUES	Heat Treatment As Welded	R _{P0,2} (MPa) 350	R _m (MPa) 590	A5 (%) 35	Hardness 190 HB
ETUVAGE	Not required				
GAS ACC. EN ISO 14175	I1, M21				



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NIFE 44MN (NI-ROD) 1,2MM

Packaging	KG/unit	EanCode
BS-300	13,60	8720663420671