



CEWELD AA FeNi

TYPE Cored welding wire developed for welding cast iron with excellent weldability.(Type NiFe-2, NiFe-CI)

APPLICATIONS **CEWELD® AA FeNi** is for Joining and repairing all types of cast iron.
Joining and rebuilding Cast Iron with globular graphite, tempered Cast Iron and for joining Cast Iron with steel. Joining and rebuilding Cast Iron with globular graphite, tempered Cast Iron. Grey cast iron, malleable, nodular

PROPERTIES **CEWELD® AA FeNi** have a very good welding and wetting characteristics and high resistance to cracks and fissures. Extreme good deposition rate compare to MMA. High strength and good bonding weld metal. Designed for welding grey, malleable, nodular and phosphorus cast iron. Preheat is not necessary. Heat input is low which favors limited heat affected zone.

CLASSIFICATION EN ISO 1071: T C NiFeT3-CI
DIN 8555: MF 23-GF-150-G

SUITABLE FOR **GG, GGG Spheroidal Cast Iron, Diluted Cast Iron, old Cast Iron, Steel to Cast Iron etc.**
Lamellar grey cast irons EN-GJL-100 to EN-GJL-350
Malleable cast irons EN-GJMB-350-10 to 650-2
Nodular cast irons EN-GJS-400-15 to EN-GJS-800-2
EN 1561: EN-GJL-100, EN-GJL-150, EN-GJL-200, EN-GJL-250, EN-GJL-300, EN-GJL-350, GG10, GG15; GG20, GG25; GG30; GG35; GG40
EN 1562: EN-GJMB-350, EN-GJMB-550 , EN- GJMW-350, EN- GJMW-550 , GTS 35, GTS 55, GTW 35, GTW 55
EN1563: EN-GJS-400-15, EN-GJS-400-18, EN-GJS-450-10, EN-GJS-500-7, EN-GJS-600-3, EN-GJS-700-2. GGG40, GGG45, GGG50, GGG60; GGG70, GGG80

APPROVALS CE

WELDING POSITIONS 

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Ni	Fe
	0.7	0.6	4	45	Rem.

ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	Hardness Brinell Hardness
	As Welded /	340	550	16	Avg. 180

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 M21, M12, M20



CEWELD AA FeNi

AA FENI 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663420824