



# CEWELD NiFe 55 Tig

TYPE	Nickel iron TIG wire for joining dissimilar materials and cast iron																
APPLICATIONS	Cast Iron repairs, rebuilding shafts, wheels, critical joints between steel and cast iron etc.																
PROPERTIES	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	<table border="0"> <tr> <td>AWS</td> <td>A 5.15: E NiFe-CI</td> </tr> <tr> <td>EN ISO</td> <td>1071: SC NiFe-1</td> </tr> <tr> <td>W.Nr.</td> <td>2.4472</td> </tr> </table>	AWS	A 5.15: E NiFe-CI	EN ISO	1071: SC NiFe-1	W.Nr.	2.4472										
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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	No Approvals Found																
WELDING POSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Ni</th> <th>Fe</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.01</td> <td>0.13</td> <td>0.7</td> <td>0.005</td> <td>0.001</td> <td>55</td> <td>Rem.</td> <td>0.03</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Ni	Fe	Cu	0.01	0.13	0.7	0.005	0.001	55	Rem.	0.03
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R<sub>p0,2</sub> MPa</th> <th>R<sub>m</sub> MPa</th> <th>A<sub>5</sub> (%)</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>300</td> <td>450</td> <td>8</td> </tr> </tbody> </table>	Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	As Welded /	300	450	8								
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As Welded /	300	450	8														
REDRYING TEMPERATURE	Not required																
GAS ACCORDING EN 14175	I1																



# CEWELD NiFe 55 Tig

	Type	KG/unit	EANCode
NIFE 55 TIG 1,6 X 1000MM	Tube	5	8720663424181
NIFE 55 TIG 2,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663420756
	Tube	5	8720663417817
NIFE 55 TIG 2,4 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663420763