



CEWELD Ni-Rod 44

TYPE	Solid Nickel-Iron-Manganese welding wire for cast iron					
APPLICATIONS	Ductile, grey and malleable Cast Iron and Cast Steel repairs, rebuilding wornout parts and also suitable for joining steel to cast Iron.					
PROPERTIES	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 extreme crack resistant.					
CLASSIFICATION	AWS	A 5.15: E NiFeMn-CI				
	EN ISO	1071: NiFeMn-CI				
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 WELD METAL (%)	C	Si	Mn	Ni	Al	Fe
	0.25	0.08	12	42	0.3	Rem.
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	Hardness Brinell Hardness	
	As Welded /1h		690	35	Avg. 190	
REDRYING TEMPERATURE	Not required					
GAS ACCORDING EN 14175	I1					