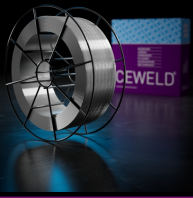




# CEWELD NiFe 44Mn (NI-ROD)

TYPE	Solid Nickel-Iron-Manganese welding wire for cast iron.				
APPLICATIONS	CEWELD NiFe 44Mn (NI-ROD) is designed for automatic and semi-automatic welding of ductile, grey and malleable cast iron and steel repairs, rebuilding of worn parts and also for joining steel to cast iron.				
PROPERTIES	<p>CEWELD NiFe 44Mn (NI-ROD) is a solid nickel-iron-manganese wire with excellent welding properties, which due to the high manganese content, allows high welding speeds. It can weld in all positions. Thermal expansion is very low (close to NILO) and the weld deposit is extremely crack resistant.</p> <p>Pre and PWHT are not normally required but may be advantageous for heavy section, fully restrained joints in low ductility castings.</p>				
CLASSIFICATION	AWS	A 5.15: ER NiFeMn-CI			
	EN ISO	1071: SC NiFeMn-CI			
	W.Nr.	UNS N02216			
SUITABLE FOR	<p>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.</p>				
APPROVALS	No Approvals Found				
WELDING POSITIONS					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	Ni	Mn	Si	C	Fe
	44	12	0.08	0.5	Rem.
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A5 (%)	Hardness Brinell Hardness
	As Welded /	350	590	35	Avg. 190
REDRYING TEMPERATURE	Not required				
GAS ACCORDING EN 14175	I1, M21				



# CEWELD NiFe 44Mn (NI-ROD)

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

Type	KG/unit	EANCode
BS-300	13,60	8720663420671