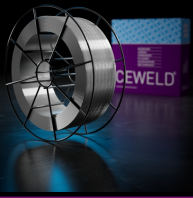


CEWELD NiFe 44Mn (NI-ROD)

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.				
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 extremely crack resistant.				
CLASSIFICATION	AWS	ER NiFeMn-CI			
	AWS	S CI 6002 (s C NiFeMn-CI			
	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 THE FILLER METAL (%)	Ni	Mn	Si	C	Fe
	44	12	0.08	1.5	Rem.
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	Hardness Brinell Hardness
	As Welded /		690	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