



CEWELD NiFe 60-40

TYPE	Welding wire for cast iron and dissimilar welding.								
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 wel 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. Very well suitable for welding with robotics or automated processes.								
CLASSIFICATION	AWS EN ISO		A 5.15: E NiFe-CI 1071: SC NiFe-1						
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, X120Mn12, 1.3401								
APPROVALS	CE DB ((62.206.01))								
WELDING POSITIONS	PAPBPC								
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Ni	Fe	Cu	Al
	0.05	0.15	0.8	0.001	0.001	58	Rem.	0.03	0.07
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)			Hardness Brinell Hardness		
	As Welded /	350	450	16			Avg. 185		
REDRYING TEMPERATURE	Not required								
GAS ACCORDING EN 14175	I1, M11, M12								



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NIFE 60-40 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663420725
Drum	250	8720663420749

NIFE 60-40 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663420732