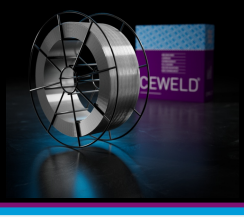

CEWELD AA NiFe 60-40

certilas® THE FILLER METAL SPECIALIST

TYPE

Nickel-Ferro type Cored wire developed for welding cast iron with excellent weldability . (Type NiFe-2, NiFe-CI)

APPLICATIONS

The weld deposit from **CEWELD ® AA NiFe 60/40** contains approximately 60% Ni and 40% Fe. It is machinable. Used for joining and repairing nearly all types of cast iron. Welding wire for GG, GGG joint and spot welding. Welding of highly restrained or thick-walled pieces.
Casings for pumps and valves, frames, machining errors on castings, crushers, gear housing etc.

PROPERTIES

CEWELD ® AA NiFe 60/40 is a high nickel and iron alloyed cored wire for cold welding of all types of gray cast iron, also in combination with steel. In particular, however, for the welding of nodular cast iron. The alloy of the weld metal is very similar in color to the base material and corrodes like it later on. The alloy has excellent crack resistance and high strength and is also suitable for multi-layer welding. The weld seam can even be machined at the transition zones

CLASSIFICATION

AWS	A 5.15: E NiFe-CI
EN ISO	1071: T-NiFe-2

SUITABLE FOR

GG, GGG Spheroidal Cast Iron, Diluted Cast Iron, old Cast Iron, Steel to Cast Iron etc.
Lamellar grey cast irons EN-GJL-100 to EN-GJL-350
Malleable cast irons EN-GJMB-350-10 to 650-2
Nodular cast irons EN-GJS-400-15 to EN-GJS-800-2
EN 1561: EN-GJL-100, EN-GJL-150, EN-GJL-200, EN-GJL-250, EN-GJL-300, EN-GJL-350, GG10, GG15; GG20, GG25; GG30; GG35; GG40
EN 1562: EN-GJMB-350, EN-GJMB-550 , EN- GJMW-350, EN- GJMW-550 , GTS 35, GTS 55, GTW 35, GTW 55
EN1563: EN-GJS-400-15, EN-GJS-400-18, EN-GJS-450-10, EN-GJS-500-7, EN-GJS-600-3, EN-GJS-700-2. GGG40, GGG45, GGG50, GGG60; GGG70, GGG80

APPROVALS

No Approvals Found

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Ni	Fe	Cu	Al
0.6	0.8	4	0.02	0.02	58	Rem.	0.3	0.05

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Hardness Brinell Hardness
As Welded /	350	470	15	Avg. 190

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

M13, M21, M12