



CEWELD Ni-Rod 44 Tig

TYPE	Tig rods for cast iron welding						
APPLICATIONS	Ductile, grey and malleable Cast Iron and Cast Steel repairs, rebuilding wornout parts and also suitable for joining steel t cast Iron.						
PROPERTIES	Very low thermal expansion therefore good crack resistance in the weldmetal						
CLASSIFICATION	AWS	A 5.15: E NiFeMn-CI					
	EN ISO	1071: NiFeMn-CI					
SUITABLE FOR	Cast iron, Cast steel						
APPROVALS	No Approvals Found						
WELDING POSITIONS							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	S	Ni	Cu	Al
	0.25	0.15	11.9	0.002	42	0.04	0.003
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						