



CEWELD NiFe 44Mn (NI-ROD)

TYPE	Solid Nickel-Iron-Manganese welding wire for cast iron.				
ANWENDUNGEN	Ductile, gray and malleable Cast Iron and cast steel repairs, rebuilding wornout parts and also suitable for joining steel to cast Iron.				
EIGENSCHAFTEN	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.				
KLASSIFIKATION	AWS EN ISO W.Nr.	A 5.15: ER NiFeMn-CI 1071: SC NiFeMn-CI UNS N02216			
GEEIGNET FÜR	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.				
ZULASSUNGEN					
SCHWEISSPOSITIONEN					
TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)	Ni 44	Mn 12	Si 0.08	C 0.5	Fe Rem.
MECHANISCHE GÜTEWERTE	Heat Treatment As Welded	R _{P0,2} (MPa) 350	R _m (MPa) 590	A5 (%) 35	Hardness 190 HB
RÜCKTROCKNUNG	Not required				
GAS ACC. EN ISO 14175	I1, M21				



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

Packaging	KG/unit	EanCode
BS-300	13,60	8720663420671