



CEWELD NiFe 55 Tig

TYPE	Nickel iron TIG wire for joining dissimilar materials and cast iron							
APPLICATIONS	Cast Iron repairs, rebuilding shafts, wheels, critical joints between steel and cast iron etc.							
PROPRIÉTÉS	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. The weld metal is corrosion and heat resistant. Very well suitable for welding with robotics or automated processes.							
CLASSIFICATION	AWS EN ISO W.Nr.	A 5.15: E NiFe-CI 1071: S C NiFe-2 2.4472						
CONVIENT POUR	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.							
AGRÉMENTS								
POSITIONS DE SOUDAGE	 PA  PB  PC  PD  PE  PF  PG							
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C	Si	Mn	P	S	Ni	Fe	Cu
	0.01	0.13	0.7	0.005	0.001	55	Rem.	0.03
PROPRIÉTÉS MÉCANIQUES	Heat Treatment		R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness		
	As Welded		300	450	8	HRc		
ETUVAGE	Not required							
GAS ACC. EN ISO 14175	I1							



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NIFE 55 TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663424181

NIFE 55 TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663420756
Tube	5	8720663417817

NIFE 55 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663420763