CEWELD NiFe 55 Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Nickel iron TIG wire for joining dissimilar materials and cast iron

TOEPASSINGEN

Cast Iron repairs, rebuilding shafts, wheels, critical joints between steel and cast iron etc.

EIGENSCHAPPEN

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 Weldabillity 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.

CLASSIFICATIE

AWS	A 5.15: E NiFe-CI
EN ISO	1071: S C NiFe-2
W.Nr.	2.4472

GESCHIKT VOOR

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.

GOEDKEURINGEN

LASPOSITIES

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Ni	Fe	Cu
0.01	0.13	0.7	0.005	0.001	55	Rem.	0.03

MECHANISCHE WAARDEN

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	300	450	8	HRc

HERDROGEN

Not required

GAS ACC. EN ISO 14175

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CEWELD NiFe 55 Tig

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