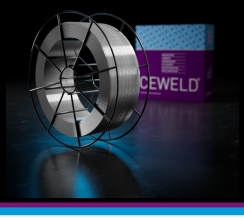

CEWELD AA NiFe 60-40

certilas® THE FILLER METAL SPECIALIST

TYPE

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

ANWENDUNGEN

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.

EIGENSCHAFTEN

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

KLASSIFIKATION

AWS	A 5.15: E NiFe-CI
EN ISO	1071: T-NiFe-2
W.Nr.	~2.4560

GEEIGNET FÜR

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

ZULASSUNGEN

SCHWEISSPOSITIONEN

TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

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

MECHANISCHE GÜTEWERTE

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

RÜCKTROCKNUNG

Not required

GAS ACC. EN ISO 14175

M13, M21, M12