



CEWELD NiFe 44Mn (NI-ROD)

TYPE Solid Nickel-Iron-Manganese welding wire for cast iron.

APPLICATIONS Ductile, gray and malleable Cast Iron and cast steel repairs, rebuilding wornout parts and also suitable for joining steel to cast Iron.

PROPRIÉTÉS 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.

CLASSIFICATION

AWS	A 5.15: ER NiFeMn-CI
EN ISO	1071: SC NiFeMn-CI
W.Nr.	UNS N02216

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



**ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL
D'APPORT (%)**

Ni	Mn	Si	C	Fe
44	12	0.08	0.5	Rem.

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	350	590	35	190 HB

ETUVAGE 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