



# 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<br>EN ISO<br>W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | A 5.15: E NiFe-CI<br>1071: S C NiFe-2<br>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                                 | <div>PAPBPCPDPEPFPG</div> |                                                 |                            |                         |           |          |      |      |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>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 <sub>p0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Hardness |      |      |
|                                                      | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                 | 300                        | 450                     | 8         | HRc      |      |      |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                 |                            |                         |           |          |      |      |
| GAS ACC. EN ISO 14175                                | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                 |                            |                         |           |          |      |      |



# 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 |