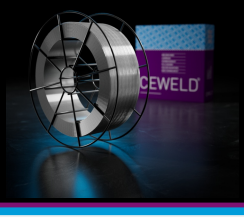

CEWELD NiFe 55

certilas® THE FILLER METAL SPECIALIST

TYPE	Nickel iron MIG wire for joining dissimilar materials and cast iron.
APPLICATIONS	Suitable for welding stainless steels containing 12-14 Cr. Also for welding mild and low alloy steels which are exposed to termperatures up to 450C. 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 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.

CLASSIFICATION

AWS	A 5.15: E NiFe-CI
EN ISO	1071: SC NiFe-1
W.Nr.	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

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Ni	Fe	Cu
0.015	0.06	0.65	0.003	0.001	55	Rem.	0.01

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	350	480	12	195 HB

ETUVAGE: Not required

GAS ACC. EN ISO 14175: I1