



CEWELD AA NiFe36

TYPE	Flux cored welding wire developed for welding cast iron with excellent weldability.				
ANWENDUNGEN	Joining and rebuilding Cast Iron with globular graphite, tempered Cast Iron and for joining Cast Iron with steel. Used for standards of length, measuring devices, laser components, bi-metal thermostat strip, thermostat rods, and tanks and piping for storing and transporting liquefied gases.				
EIGENSCHAFTEN	Very good welding and wetting characteristics and high resistance to cracks and fissures. Extreme good deposition rate compare to MMA. High strength and good bonding weld metal. NiFe36 has a composition that matches "NiLo" and offer the lowest shrinkage possible to avoid cracks during heating and the cooling period. The weld deposit also retains good strength and toughness at cryogenic temperatures and has a low coefficient of expansion from cryogenic temperatures to about 500°F (260°C).				
KLASSIFIKATION	AWS EN ISO W.Nr.	A 5.15: E NiFe-CI 1071: T C NiFe-1 1.3912			
GEEIGNET FÜR	Spheroidal Cast Iron, Diluted Cast Iron, old Cast Iron, Steel to Cast Iron etc. 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	 PA  PB  PC				
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	Ni	Fe
	0.1	0.5	2.4	36	Rem.
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
	As Welded				150 HV
RÜCKTROCKNUNG	Not required				
GAS ACC. EN ISO 14175	I1, M13				