



# CEWELD NiFe 60-40

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                 |                         |       |                      |    |        |          |      |
|---------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------|-------------------------|-------|----------------------|----|--------|----------|------|
| TYPE                                              | Welding wire for cast iron and dissimilar welding.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                 |                         |       |                      |    |        |          |      |
| APPLICATIONS                                      | CEWELD® NiFe 60-40 is ideal for welding mixed joints, for example, cast iron, high-alloy, stainless, and heat-resistant steels, as well as structural steels. It is also ideal for thick-walled workpieces and steels with low carbon content. Examples include housings for pumps and valves, frames, and machining errors on castings, crushers, and gearboxes.                                                                                                                                                                                                                                                                                                                                |                                                 |                         |       |                      |    |        |          |      |
| PROPERTIES                                        | CEWELD® NiFe 60-40 (~60% Ni, ~40% Fe) is a nickel-iron-based welding consumable. It has excellent weldability with extreme crack resistance and ductile weld metal. The color of the weld metal alloy is similar to that of the base material and corrodes in the same way. It has good welding and wetting properties as well as high resistance to porosity. It is very well suited for welding with robots or automated processes.                                                                                                                                                                                                                                                            |                                                 |                         |       |                      |    |        |          |      |
| CLASSIFICATION                                    | AWS<br>EN ISO<br>W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | A 5.15: ER NiFe-CI<br>1071: SC NiFe-1<br>2.4560 |                         |       |                      |    |        |          |      |
| SUITABLE FOR                                      | <b>GG, GGG Spheroidal Cast Iron, Diluted Cast Iron, old Cast Iron, Steel to Cast Iron etc.</b><br><b>Lamellar grey cast irons</b> EN-GJL-100 to EN-GJL-350<br><b>Malleable cast irons</b> EN-GJMB-350-10 to 650-2<br><b>Nodular cast irons</b> EN-GJS-400-15 to EN-GJS-800-2<br><b>EN 1561:</b> 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<br><b>EN 1562:</b> EN-GJMB-350, EN-GJMB-550 , EN- GJMW-350, EN- GJMW-550 , GTS 35, GTS 55, GTW 35, GTW 55<br><b>EN1563:</b> 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<br>X120Mn12, 1.3401 |                                                 |                         |       |                      |    |        |          |      |
| APPROVALS                                         | CE, DB: (62.206.01)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                 |                         |       |                      |    |        |          |      |
| WELDING POSITIONS                                 | <div>  </div>                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                 |                         |       |                      |    |        |          |      |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Si                                              | Mn                      | P     | S                    | Ni | Fe     | Cu       | Al   |
|                                                   | 0.05                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 0.15                                            | 0.8                     | 0.001 | 0.001                | 58 | Rem.   | 0.03     | 0.07 |
| MECHANICAL PROPERTIES                             | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                 | R <sub>P0,2</sub> (MPa) |       | R <sub>m</sub> (MPa) |    | A5 (%) | Hardness |      |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                 | 200                     |       | 400                  |    | 16     | 185 HB   |      |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                 |                         |       |                      |    |        |          |      |
| GAS ACC. EN ISO 14175                             | I1, M11, M12                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                 |                         |       |                      |    |        |          |      |



# CEWELD NiFe 60-40

NIFE 60-40 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663420725 |
| Drum      | 250     | 8720663420749 |

NIFE 60-40 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663420732 |