



# CEWELD NiFe 55

|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                |                            |                         |           |          |      |      |
|------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------|----------------------------|-------------------------|-----------|----------|------|------|
| 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 temperatures 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 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: SC NiFe-1<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>PAPBPCPEPF</div>                                                           |                                                |                            |                         |           |          |      |      |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | 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 <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Hardness |      |      |
|                                                      | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                | 350                        | 480                     | 12        | 195 HB   |      |      |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                |                            |                         |           |          |      |      |
| GAS ACC. EN ISO 14175                                | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                |                            |                         |           |          |      |      |