




# CEWELD AA FeNi

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.										
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..										
KLASSIFIKATION	EN ISO                    1071: T C NiFeT3-CI DIN                        8555: MF 23-GF-150-G										
GEEIGNET FÜR	<b>GG, GGG Spheroidal Cast Iron, Diluted Cast Iron, old Cast Iron, Steel to Cast Iron etc.</b> <b>Lamellar grey cast irons</b> EN-GJL-100 to EN-GJL-350 <b>Malleable cast irons</b> EN-GJMB-350-10 to 650-2 <b>Nodular cast irons</b> EN-GJS-400-15 to EN-GJS-800-2 <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 <b>EN 1562:</b> EN-GJMB-350, EN-GJMB-550 , EN- GJMW-350, EN- GJMW-550 , GTS 35, GTS 55, GTW 35, GTW 55 <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										
ZULASSUNGEN	CE										
SCHWEISSPOSITIONEN											
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th style="width: 20%;">C</th> <th style="width: 20%;">Si</th> <th style="width: 20%;">Mn</th> <th style="width: 20%;">Ni</th> <th style="width: 20%;">Fe</th> </tr> </thead> <tbody> <tr> <td>0.7</td> <td>0.6</td> <td>4</td> <td>45</td> <td>Rem.</td> </tr> </tbody> </table>	C	Si	Mn	Ni	Fe	0.7	0.6	4	45	Rem.
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MECHANISCHE GÜTEWERTE	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th style="width: 25%;">Heat Treatment</th> <th style="width: 20%;">R<sub>P0,2</sub> (MPa)</th> <th style="width: 20%;">R<sub>m</sub> (MPa)</th> <th style="width: 15%;">A<sub>5</sub> (%)</th> <th style="width: 20%;">Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>340</td> <td>550</td> <td>16</td> <td>180 HB</td> </tr> </tbody> </table>	Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness	As Welded	340	550	16	180 HB
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As Welded	340	550	16	180 HB							
RÜCKTROCKNUNG	140°C / 24 hr										
GAS ACC. EN ISO 14175	M21, M12, M20										



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AA FENI 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663420824