



CEWELD Ni-Rod 44 Tig

TYPE Tig rods for cast iron welding

APPLICATIONS Ductile, grey and malleable Cast Iron and Cast Steel repairs, rebuilding wornout parts and also suitable for joining steel t cast Iron.

PROPRIÉTÉS Very low thermal expansion therefore good crack resistance in the weldmetal

CLASSIFICATION AWS A 5.15: E NiFeMn-CI
EN ISO 1071: NiFeMn-CI

CONVIENT POUR Cast iron, Cast steel

AGRÉMENTS

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | S | Ni | Cu | Al |
|------|------|------|-------|----|------|-------|
| 0.25 | 0.15 | 11.9 | 0.002 | 42 | 0.04 | 0.003 |

PROPRIÉTÉS MÉCANIQUES

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A5 (%) | Hardness |
|----------------|-------------------------|----------------------|--------|----------|
| As Welded | | 690 | 35 | 190 HB |

ETUVAGE Not required

GAS ACC. EN ISO 14175 I1