CEWELD®

AA NiFe36

CATEGORY	FCAW Flux-Cored
TYPE	Flux cored welding wire developed for welding cast iron with excellent weldability.
APPLICATIONS	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.
PROPERTIES	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 schrinkage 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).
CLASSIFICATION	EN ISO 1071:~T NiFe-CI DIN: W.Nr. 1.3912 DIN 17006: Ni 36
SUITABLE FOR	Joining and rebuilding Cast Iron with globular graphite, tempered Cast Iron and for joining Cast Iron with steel,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
APPROVALS	CE approved
WELDING POSITIONS:	

WELD METAL WEIGHT %

C	Mn	Si	Fe	Ni	Others
0.1	2.45	0.45	Rem	35-37	<0.75

MECHANICAL PROPERTIES (TYPICAL)

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C	Hardness HV
AW at RT	240	490	38				150-220

AW = as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.6	21-27	150-250	S-300	15	1080

REDRYING TEMPERATURE	150 ºC / 24hr
GAS ACC. EN ISO 14175:	I1, M13, Ar99/O1