

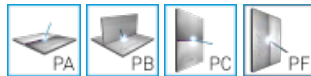


CEWELD Ni-Rod 44 Tig

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.	
PROPERTIES	Very low thermal expansion therefore good crack resistance in the weldmetal	
CLASSIFICATION	AWS EN ISO	A 5.15: E NiFeMn-Cl 1071: NiFeMn-Cl
SUITABLE FOR	Cast iron, Cast steel	

APPROVALS

WELDING POSITIONS



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

MECHANICAL PROPERTIES

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

REDRYING Not required

GAS ACC. EN ISO 14175 I1