



# CEWELD NiFe 55

**TYPE** Nickel iron MIG wire for joining multiple pass welding cast iron. (NiFe-1, 2.4472)

**APPLICATIONS** CEWELD® NiFe 55 is suitable for welding mild and low alloy steels which are exposed to temperatures up to 450C. Multiple pass welding of spheroidal graphite cast irons and neutral tempered (black) malleable cast irons. Cast Iron repairs, rebuilding shafts, wheels, critical joints between steel and cast iron etc.

**PROPERTIES** CEWELD® NiFe 55 is a nickel Iron based filler metal for joint welding and claddings on cast Iron. Very well 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    | A 5.15: E NiFe-CI |
| EN ISO | 1071: SC NiFe-1   |
| W.Nr.  | 2.4472            |

**SUITABLE FOR** 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**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

| C     | Si   | Mn   | P     | S     | Ni | Fe   | Cu   |
|-------|------|------|-------|-------|----|------|------|
| 0.015 | 0.06 | 0.65 | 0.003 | 0.001 | 55 | Rem. | 0.01 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      | 350                     | 480                  | 12                 | 195 HB   |

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1