


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	GG, GGG Spheroidal Cast Iron, Diluted Cast Iron, old Cast Iron, Steel to Cast Iron etc. Lamellar grey cast irons EN-GJL-100 to EN-GJL-350 Malleable cast irons EN-GJMB-350-10 to 650-2 Nodular cast irons EN-GJS-400-15 to EN-GJS-800-2 EN 1561: 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 EN 1562: EN-GJMB-350, EN-GJMB-550 , EN- GJMW-350, EN- GJMW-550 , GTS 35, GTS 55, GTW 35, GTW 55 EN1563: 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_{P0,2} (MPa)</th> <th style="width: 20%;">R_m (MPa)</th> <th style="width: 15%;">A₅ (%)</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 _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	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