



# CEWELD AA NiFe 60-40

**TYPE** Nickel-Ferro type Cored wire developed for welding cast iron with excellent weldability . (Type NiFe-2, NiFe-Cl)

**APPLICATIONS** The weld deposit from **CEWELD® AA NiFe 60/40** contains approximately 60% Ni and 40% Fe. It is machinable. Used for joining and repairing nearly all types of cast iron. Welding wire for GG, GGG joint and spot welding. Welding of highly restrained or thick-walled pieces. Casings for pumps and valves, frames, machining errors on castings, crushers, gear housing etc.

**PROPERTIES** **CEWELD® AA NiFe 60/40** is a high nickel and iron alloyed cored wire for cold welding of all types of gray cast iron, also in combination with steel. In particular, however, for the welding of nodular cast iron. The alloy of the weld metal is very similar in color to the base material and corrodes like it later on. The alloy has excellent crack resistance and high strength and is also suitable for multi-layer welding. The weld seam can even be machined at the transition zones

**CLASSIFICATION**

|        |                   |
|--------|-------------------|
| AWS    | A 5.15: E NiFe-Cl |
| EN ISO | 1071: T-NiFe-2    |
| W.Nr.  | ~2.4560           |

**SUITABLE FOR** **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

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C   | Si  | Mn | P    | S    | Ni | Fe   | Cu  | Al   |
|-----|-----|----|------|------|----|------|-----|------|
| 0.6 | 0.8 | 4  | 0.02 | 0.02 | 58 | Rem. | 0.3 | 0.05 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      | 300                     | 420                  | 15                 | 190 HB   |

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M13, M21, M12