

## NiFe 44Mn (NI-ROD)

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Solid Nickel-Iron-Manganese welding wire for cast iron.

**APPLICATIONS** Ductile, gray and malleable Cast Iron and cast steel repairs, rebuilding wornout parts and also suitable for joining steel to cast iron.

**PROPERTIES** Excellent wetting properties that enable this welding wire to weld with high welding speed due to the high manganese content. Thermal expansion is very low (close to NILO) and the weld deposit is extremely crack resistant.

**CLASSIFICATION**

AWS	A 5.15: ER NiFeMn-CI UNS N02216
EN ISO	1071: S CI 6002 (S C NiFeMn-CI)
DIN	1736:

**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** CE approved

**WELDING POSITIONS:**

**WELD WIRE ANALYSIS**

Ni	Mn	C	Fe
44	11	1.5	45

**MECHANICAL PROPERTIES**

Heat Treatment	Tensile strength		A4 (%)	Impact Energy (J) ISO-V			Hardness HB
	psi	MPa		-20°C	-40°C	-60°C	
AW	100.000	690	35				190

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters			Packing		
	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet	
0.9	15-24	80-220	D-300	13.6	979.2	
1.2	17-29	150-290	D-300	13.6	979.2	

**REDRYING TEMPERATURE** not required

**TIG WELDING** Tig rods are available in 1000 mm lenght in 1,6 and 2,4 mm (4,54 kg tubes)