



NI-ROD[®] 44 Filler Metal

NI-ROD 44 Filler Metal is a solid, nickel-iron-manganese wire designed for automatic and semi-automatic welding of ductile, malleable and gray cast irons in all positions. Submerged-arc welding is done with INCOFLUX NT100 Submerged Arc Flux.

NI-ROD 44 Filler Metal offers high-speed, high-quality welds, and can be used with all robotics, automatic and semi-automatics processes, and in all positions. It provides the wetting and crack-resistant weldability that allows steel forgings and castings to be re-designed in less expensive ductile iron and welded automatically.

Pre- and post-weld heat treatments are not usually required but may be advantageous for heavy section, fully restrained joints in low ductility castings.

Specifications

AWS A5.15 ERNiFeMn-CI (UNS N02216)

ASME II, Part C, SFA5.15 ERNiFeMn-CI (UNS N02216)

* (EN) ISO 1071 - S CI 6002 (S C NiFeMn-CI)

* Supply to these specifications available upon request

For manufacture to ASME III (NCA3800, NB2400), and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Typical Chemical Composition

Ni.....	44	Mn	11
C.....	1.5	Fe.....	45

Typical Mechanical Properties

Tensile Strength, psi	100,000
MPa	690
Elongation, (4d) %	35

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

Available Product Forms

	0.8 0.030	0.9 0.035	1.0 0.040	1.14 0.045	1.2 0.047	1.6 0.062	2.4 0.093	3.2 0.125
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Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)