

## Cast Iron Filler Metal

### NI-ROD<sup>®</sup> 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.

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   | 0.9   | 1.0   | 1.14  | 1.2   | 1.6   | 2.4   | 3.2   |
|  | 0.030 | 0.035 | 0.040 | 0.045 | 0.047 | 0.062 | 0.093 | 0.125 |

| Diam. | 13.62 kg Spool |
|-------|----------------|
| 1.2mm | SMMNIROD4412   |

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