



CEWELD E NiFe 60/40 K

TYPE

APPLICATIONS

PROPRIÉTÉS

CLASSIFICATION

CONVIENT POUR

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL DE
SOUDURE (%)

PROPRIÉTÉS MÉCANIQUES

ETUVAGE

GAS ACC. EN ISO 14175

Special coated electrode with copper coated core wire for welding cast iron with high tensile strength.

CEWELD E NiFe 60/40 K is suitable for welding grey and malleable cast iron, equally suitable for SG iron. Use this type in case a high tensile strength is required and due to the special coating to weld in difficult welding positions.

CEWELD E NiFe 60/40 K has a few benefits compare to other “FeNi” types because of improvements, such as: weldable with very low current, copper coated core wire and a powerful arc at very low amps. Preheating is normally done to slow down the cooling speed, in case you can not control the cooling speed it is better to keep the work peace at a low temperature during welding and hammer immediately after welding.

AWS
EN ISO
W.Nr.

A 5.15: E NiFe-CI
1071: E C NiFe-CI
~2.4560

Spheroidal Cast Iron, Diluted Cast Iron, old Cast Iron, Steel to Cast Iron etc.
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

CE

PA

PB

PC

PD

PE

PF

C	Si	Mn	Ni	Fe	Cu
1.1	1.2	1.1	55	Rem.	0.6

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded	350	500	10	190 HB

140°C / 1 hr



CEWELD E NiFe 60/40 K

E NIFE 60/40 K 3,2 X 350MM	Packaging	KG/unit	EanCode
	Can	3,4	8720663420794