









CEWELD E Ni

TYPE	Special coated electrode for welding cast iron with a pure nickel core wire.				
APPLICATIONS	Joining and cladding grey and malleable cast iron, also suitable for joint welds between steel , Copper and Copper Alloys, especially for maintenance and repair.				
PROPERTIES	Excellent welding properties with easily controllable flow permits spatter free welding with very low current. Due to the very low heat input and unique composition of Ni the transition zone will stay well machinable and is therefore well suited to use as first layer in case off multi-layer welding. The weld metal will show no undercut !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.				
CLASSIFICATION	AWS EN ISO	A 5.15: E Ni-Cl 1071: E C Ni-Cl-1			
SUITABLE FOR	Grey Cast Iron, EN 1561: EN-GjL-150, EN-GjL-200, EN-GjL-250, EN-GjL-300, EN-GjL-350, GG-15, GG-20, GG-25, GG-30, GG-35, GG-40, EN 1563: EN-GJS-400-15, EN-GJS-400-18, EN-GJS-450-10, EN-GJS-500-7, EN-GJS-600-3, EN-GJS-700-2 G GG-40, G GG-45, G GG-50, G GG-60, G GG-70, G GG-80 Malleable cast iron: EN GJMB 350 - ENGJMB 650				
APPROVALS	CE				
WELDING POSITIONS	     				
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C 0.1	Si 0.2	Mn 1.5	Ni Rem.	Fe 2
ALL WELD MECHANICAL PROPERTIES	Heat Treatment As Welded /	R _{P0,2} MPa	R _m MPa	A5 (%)	Hardness Brinell Hardness Avg. 160
REDRYING TEMPERATURE	140°C / 2 hr				
GAS ACCORDING EN 14175					



CEWELD E Ni

E NI 2,5 X 300MM

Type	KG/unit	EANCode
Can	3,5	8720663420589

E NI 3,2 X 350MM

Type	KG/unit	EANCode
Can	3,5	8720663420572