




CEWELD E NiFe 60/40 K

TYPE	Special coated electrode with copper coated core wire for welding cast iron with high tensile strength.					
APPLICATIONS	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.					
PROPERTIES	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.					
CLASSIFICATION	AWS EN ISO	A 5.15: E NiFe-CI 1071: E C NiFe-CI				
SUITABLE FOR	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					
APPROVALS	CE					
WELDING POSITIONS						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Ni	Fe	Cu
	1.1	1.2	1.1	55	43	0.6
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)	Hardness Brinell Hardness	
	As Welded /	350	500	10	Avg. 190	
REDRYING TEMPERATURE	140°C / 1 hr					
GAS ACCORDING EN 14175						



CEWELD E NiFe 60/40 K

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