









CEWELD E NiFe 2

TYPE	Special “bimetal” core wire coated electrode for welding cast iron with high tensile strength.				
APPLICATIONS	CEWELD E NiFe 2 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 or because of his non overheating coating. Also suitable for joining steel to cast iron !				
PROPERTIES	CEWELD E NiFe 2 has a few benefits compare to other “FeNi” types because of improvements, such as: weldable with very low current, non overheating coating and a powerful arc at very low amps. The deposit is free from porosity even on old and or otherwise diluted base material. 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	<div>PAPBPCPDPEPF</div>				
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C 1.5	Si 1.5	Mn 1	Ni 55	Fe 42
ALL WELD MECHANICAL PROPERTIES	Heat Treatment As Welded /	R _{p0,2} MPa	R _m MPa 400	A5 (%)	Hardness Brinell Hardness Avg. 200
REDRYING TEMPERATURE	140°C / 2 hr				
GAS ACCORDING EN 14175					