




# CEWELD E FeNi 60 N

TYPE	Special coated electrode for welding cast iron with high tensile strength.													
APPLICATIONS	CEWELD E FeNi 60 N 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 conductive coating to weld in difficult welding positions where coating contact is unavoidable with the base metal.													
PROPERTIES	CEWELD E FeNi 60 N has a few benefits compare to other "FeNi" types because of improvements, such as: weldable with very low current, non conductive coating 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-1												
SUITABLE FOR	Spheroidal Cast Iron, Diluted Cast Iron, old Cast Iron, Steel to Cast Iron etc. <b>EN 1561:</b> 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 <b>EN 1562:</b> EN-GJMB-350, EN-GJMB-550 , EN- GJMW-350, EN- GJMW-550 , GTS 35, GTS 55, GTW 35, GTW 55 <b>EN1563:</b> 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 (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td>C</td> <td>Si</td> <td>Mn</td> <td>Ni</td> <td>Fe</td> <td>Cu</td> </tr> <tr> <td>0.5</td> <td>0.1</td> <td>0.5</td> <td>55</td> <td>43</td> <td>0.03</td> </tr> </table>		C	Si	Mn	Ni	Fe	Cu	0.5	0.1	0.5	55	43	0.03
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td>Heat Treatment</td> <td>R<sub>P0,2</sub> MPa</td> <td>R<sub>m</sub> MPa</td> <td>A5 (%)</td> <td>Hardness Brinell Hardness</td> </tr> <tr> <td>As Welded /</td> <td></td> <td>400</td> <td></td> <td>Avg. 200</td> </tr> </table>		Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A5 (%)	Hardness Brinell Hardness	As Welded /		400		Avg. 200		
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As Welded /		400		Avg. 200										
REDRYING TEMPERATURE	140°C / 2 hr													
GAS ACCORDING EN 14175														



# CEWELD E FeNi 60 N

E FENI 60 N 2,5 X 300MM	Type	KG/unit	EANCode
	Can	2,7	8720663420626
E FENI 60 N 3,2 X 350MM	Type	KG/unit	EANCode
	Can	3,5	8720663420633
E FENI 60 N 4,0 X 350MM	Type	KG/unit	EANCode
	Can	3,2	8720663420640