



CEWELD E Ni(-)

TYPE	Pure nickel core elektrode special coated for welding cast iron.															
APPLICATIONS	<p>CEWELD®E Ni(-) is for joining and cladding gray and malleable cast iron, also suitable for joint welding between steel, copper and copper alloys, especially for maintenance and repair. Also for joining with steel, copper and monel.</p> <p>Areas of application are: Power generation industry, build-up welding and repairs, petrochemical and chemical industry, industry</p>															
PROPERTIES	<p>CEWELD®E Ni(-) exhibits excellent welding properties with easily controllable flow behavior and enables spatter-free welding with very low current. Due to the very low heat input and the unique composition of Ni, the transition zone remains easily workable and is therefore well suited as the first layer in multi-layer welding. The weld metal has no bonding defects!</p> <p>Preheating is recommended to slow down the cooling rate, if you cannot control the cooling rate, it is better to keep the workpiece at a low temperature during welding and hammer immediately after welding.</p>															
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.15: E Ni-CI</td> </tr> <tr> <td>EN ISO</td> <td>1071: E C Ni-CI-1</td> </tr> </table>	AWS	A 5.15: E Ni-CI	EN ISO	1071: E C Ni-CI-1											
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SUITABLE FOR	<p>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,</p> <p>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</p> <p>Malleable cast iron: EN GJMB 350 - ENGJMB 650</p>															
APPROVALS	CE															
WELDING POSITIONS																
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 20%;">C</td> <td style="width: 20%;">Si</td> <td style="width: 20%;">Mn</td> <td style="width: 20%;">Ni</td> <td style="width: 20%;">Fe</td> </tr> <tr> <td>0.6</td> <td>0.4</td> <td>0.6</td> <td>Rem.</td> <td>0.6</td> </tr> </table>	C	Si	Mn	Ni	Fe	0.6	0.4	0.6	Rem.	0.6					
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 30%;">Heat Treatment</td> <td style="width: 10%;">R_{P0,2}</td> <td style="width: 10%;">R_m</td> <td style="width: 10%;">A₅</td> <td style="width: 40%;">Hardness</td> </tr> <tr> <td>As Welded /</td> <td>MPa</td> <td>MPa</td> <td>(%)</td> <td>Brinell Hardness</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td>Avg. 160</td> </tr> </table>	Heat Treatment	R _{P0,2}	R _m	A ₅	Hardness	As Welded /	MPa	MPa	(%)	Brinell Hardness					Avg. 160
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REDRYING TEMPERATURE	140°C / 2 hr															
GAS ACCORDING EN 14175																



CEWELD E Ni(-)

E Ni(-) 2,5 X 350MM

Type	KG/unit	EANCode
Can	3,5	8720663420558

E Ni(-) 3,2 X 350MM

Type	KG/unit	EANCode
Can	3,5	8720663420565

E Ni(-) 4,0 X 350MM

Type	KG/unit	EANCode
Can	3,5	8720663420596