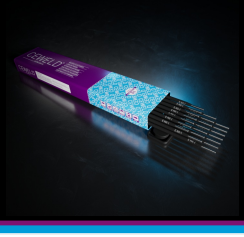


CEWELD E Ni(-)

certilas® THE FILLER METAL SPECIALIST

TYPE

Pure nickel core elektrode special coated for welding cast iron.

APPLICATIONS

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.
Areas of application are:
Power generation industry, build-up welding and repairs, petrochemical and chemical industry, industry

PROPERTIES

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!
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.

CLASSIFICATION

AWS	A 5.15: E Ni-Cl
EN ISO	1071: E C Ni-Cl-1

SUITABLE FOR

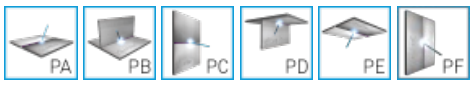
Grey Cast Iron, EN 1561: EN-GjL-150, EN-GjL-200, EN-GjL-250, EN-GjL-300, EN-GjL-350, GG-15, GG-20, GG-25, GG-30, GG-35, GG-40,
EN 1563: EN-GJS-400-15, EN-GJS-400-18, EN-GJS-450-10, EN-GJS-500-7, EN-GJS-600-3, EN-GJS-700-2 G GG-40, G GG-45, G GG-50, G GG-60, G GG-70, G GG-80

Malleable cast iron: EN GJMB 350 - ENGJMB 650

APPROVALS

CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Ni	Fe
0.6	0.4	0.6	Rem.	0.6

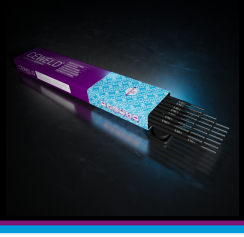
ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Hardness Brinell Hardness
As Welded /				Avg. 160

REDRYING TEMPERATURE

140°C / 2 hr

GAS ACCORDING EN 14175



CEWELD E Ni(-)

certilas® THE FILLER METAL SPECIALIST

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