



CEWELD E NiFe 60/40 K

certilas® THE FILLER METAL SPECIALIST

TYPE	Special coated electrode with copper coated core wire for welding cast iron with high tensile strength.																	
APPLICATIONS	<p>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.</p> <p>Main application: For foundry defects, repairing of engine blocks, frame of tool machines, gearboxes, reducing pieces, pump bodies, valve bodies.</p>																	
PROPERTIES	<p>CEWELD® E NiFe 60/40 K is a ferro-nickel alloy (55%Ni - 45%Fe)</p> <p>The most important advantage of this electrode: exceptional resistance to overheating during welding and exceptional welding properties</p>																	
CLASSIFICATION	<p>AWS A 5.15: E NiFe-Cl EN ISO 1071: E C NiFe-Cl W.Nr. ~2.4560</p>																	
SUITABLE FOR	<p>Spheroidal Cast Iron, Diluted Cast Iron, old Cast Iron, Steel to Cast Iron etc.</p> <p>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</p> <p>EN 1562: EN-GJMB-350, EN-GJMB-550, EN-GJMW-350, EN-GJMW-550, GTS 35, GTS 55, GTW 35, GTW 55</p> <p>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</p>																	
APPROVALS	CE																	
WELDING POSITIONS																		
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th><th>Si</th><th>Mn</th><th>Ni</th><th>Fe</th><th>Cu</th></tr> </thead> <tbody> <tr> <td>1.1</td><td>1.2</td><td>1.1</td><td>55</td><td>Rem.</td><td>0.6</td></tr> </tbody> </table>						C	Si	Mn	Ni	Fe	Cu	1.1	1.2	1.1	55	Rem.	0.6
C	Si	Mn	Ni	Fe	Cu													
1.1	1.2	1.1	55	Rem.	0.6													
MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th><th>R_{P0.2} (MPa)</th><th>R_m (MPa)</th><th>A5 (%)</th><th>Hardness</th></tr> </thead> <tbody> <tr> <td>As Welded</td><td>350</td><td>500</td><td>10</td><td>190 HB</td></tr> </tbody> </table>						Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness	As Welded	350	500	10	190 HB		
Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness														
As Welded	350	500	10	190 HB														
REDRYING	140°C / 1 hr																	

GAS ACC. EN ISO 14175



CEWELD E NiFe 60/40 K

certilas® THE FILLER METAL SPECIALIST

E NIFE 60/40 K 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	3,4	8720663420794