



CEWELD E NiFe 2

TYPE	Special "bimetal" core wire coated electrode for welding cast iron with high tensile strength.										
APPLICATIONS	<p>CEWELD® E NiFe 2 is suitable for welding gray and malleable cast iron, as well as ductile cast iron. Use this type when high tensile strength is required or because of its non-overheating coating. Also suitable for joining steel to cast iron!</p> <p>For industrial applications such as: Power generation industry, overlay welding and repairs Construction and mechanical engineering, metallurgy (steelworks), mining, agriculture, lightweight construction.</p>										
PROPERTIES	<p>CEWELD® E NiFe 2 offers several advantages compared to other "FeNi" grades due to improvements such as: weldable at very high current. The coating structure is not susceptible to overheating and produces a strong arc even at low amperages.</p> <p>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 NiFe-CI</td> </tr> <tr> <td>EN ISO</td> <td>1071: E C NiFe-CI</td> </tr> </table>	AWS	A 5.15: E NiFe-CI	EN ISO	1071: E C NiFe-CI						
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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> </tr> </thead> <tbody> <tr> <td>1.5</td> <td>1.5</td> <td>1</td> <td>55</td> <td>Rem.</td> </tr> </tbody> </table>	C	Si	Mn	Ni	Fe	1.5	1.5	1	55	Rem.
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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>>296</td> <td>400</td> <td>>6</td> <td>200 HB</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	As Welded	>296	400	>6	200 HB
Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness							
As Welded	>296	400	>6	200 HB							
REDRYING	140°C / 2 hr										
GAS ACC. EN ISO 14175											