



CEWELD E NiFe 60/40 K

TYPE

APPLICATIONS

PROPERTIES

CLASSIFICATION

SUITABLE FOR

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

MECHANICAL PROPERTIES

REDRYING

GAS ACC. EN ISO 14175

Special coated electrode with copper coated core wire for welding cast iron with high tensile strength.

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.
Main application: For foundry defects, repairing of engine blocks, frame of tool machines, gearboxes, reducing pieces, pump bodies, valve bodies.

CEWELD® E NiFe 60/40 K is a ferro-nickel alloy (55%Ni - 45%Fe)
The most important advantage of this electrode: exceptional resistance to overheating during welding and exceptional welding properties

AWS
EN ISO
W.Nr.

A 5.15: E NiFe-Cl
1071: E C NiFe-Cl
~2.4560

Spheroidal Cast Iron, Diluted Cast Iron, old Cast Iron, Steel to Cast Iron etc.
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
EN 1562: EN-GJMB-350, EN-GJMB-550 , EN- GJMW-350, EN- GJMW-550 , GTS 35, GTS 55, GTW 35, GTW 55
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

CE

PA

PB

PC

PD

PE

PF

C	Si	Mn	Ni	Fe	Cu
1.1	1.2	1.1	55	Rem.	0.6

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded	350	500	10	190 HB

140°C / 1 hr



CEWELD E NiFe 60/40 K

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

Packaging	KG/unit	EanCode
Can	3,4	8720663420794