



CEWELD E NiFe 60/40 K

TYPE	Special coated electrode with copper coated core wire for welding cast iron with high tensile strength.
APPLICATIONS	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.
PROPRIÉTÉS	CEWELD E NiFe 60/40 K has a few benefits compare to other "FeNi" types because of improvements, such as: weldable with very low current, copper coated core wire and a powerful arc at very low amps. Preheating is normally done to slow down the cooling speed, in case you can not control the cooling speed it is better to keep the work piece at a low temperature during welding and hammer immediately after welding.

CLASSIFICATION	AWS	A 5.15: E NiFe-CI
	EN ISO	1071: E C NiFe-CI
	W.Nr.	~2.4560

CONVIENT POUR	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
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AGRÉMENTS	CE
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POSITIONS DE SOUDAGE	     
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ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	Ni	Fe	Cu
	1.1	1.2	1.1	55	Rem.	0.6

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

ETUVAGE	140°C / 1 hr
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GAS ACC. EN ISO 14175	
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CEWELD E NiFe 60/40 K

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

Packaging	KG/unit	EanCode
Can	3,4	8720663420794