



CEWELD E Ni(-)

TYPE Special coated electrode for welding cast iron with a pure nickel core wire.

ANWENDUNGEN Joining and cladding grey and Malleable Cast Iron, also suitable for joint welds between steel , Copper and Copper Alloys, especially for maintenance and repair.

EIGENSCHAFTEN Excellent welding properties with easily controllable flow permits spatter free welding with very low current. Due to the very low heat input and unique composition of CEWELD E Ni(-) the transition zone will stay well machinable and is therefore well suited to use as first layer in case off multi-layer welding. The weld metal will show no undercut !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 peace at a low temperature during welding and hammer immediately after welding.

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

GEEIGNET FÜR Grey Cast Iron, Malleable cast iron, EN 1561: EN-GJL-100 (GG10) till EN-GJL-350 (GG35), EN 1562: EN-GJMB-350 (GTS 35) till EN-GJMB-550 (GTS 55), EN- GJMW-350 (GTW 35) till EN- GJMW-550 (GTW 55).

ZULASSUNGEN CE

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Ni	Fe	Cu
0.1	0.2	1.5	Rem.	2	1.5

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	>262	>276	>3	160 HB

RÜCKTROCKNUNG 140°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E Ni(-)

E NI(-) 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	3,5	8720663420558

E NI(-) 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	3,5	8720663420565

E NI(-) 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	3,5	8720663420596