



CEWELD E FeNi 60

TYPE	Special coated electrode for welding cast iron with high tensile strength.					
APPLICATIONS	CEWELD E FeNi 60 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 or because of his non conductive coating to weld in difficult welding positions where coating contact is unavoidable with the base metal.					
PROPERTIES	CEWELD E FeNi 60 has a few benefits compare to other "FeNi" types because of improvements, such as: weldable with very low current, non conductive coating 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 peace at a low temperature during welding and hammer immediately after welding.					
CLASSIFICATION	AWS EN ISO	A 5.15: E NiFe-CI 1071: E C NiFe-1				
SUITABLE FOR	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					
APPROVALS	CE					
WELDING POSITIONS	PAPBPCPEPF					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Ni	Fe	Cu
	0.5	0.1	0.5	55	Rem.	0.03
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	
	As Welded	>296	400	>6	225 HB	
REDRYING	140°C / 2 hr					
GAS ACC. EN ISO 14175						



CEWELD E FeNi 60

E FENI 60 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,7	8720663420626

E FENI 60 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	3,5	8720663420633

E FENI 60 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	3,2	8720663420640