



# CEWELD E HGW

TYPE	Covered electrode for cold welding dirty and old cast Iron parts				
APPLICATIONS	E HGW is recommended for welding cast iron that require the same colour at the repair area and in case Nickel or Fe-Nickel electrodes fail to offer proper bonding properties. Often used as buffer layer prior to Ni. or NiFe types.				
PROPERTIES	Easy to apply and excelent for use on dirty and old cast iron parts that are difficult to weld (bonding problems). The weld deposit can be machined by grinding and is not corrosion resistant.				
CLASSIFICATION	AWS	A 5.15: ESt			
SUITABLE FOR	cast iron				
APPROVALS					
WELDING POSITIONS					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Fe	
	0.2	0.1	0.7	Rem.	
MECHANICAL PROPERTIES	Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Hardness
	As Welded				180 HB
REDRYING	Not required				
GAS ACC. EN ISO 14175					