



CEWELD E FeNi 60 N

TYPE Special coated electrode for welding cast iron with high tensile strength.

APPLICATIONS CEWELD E FeNi 60 N 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 N 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 A 5.15: E NiFe-CI
EN ISO 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



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)	A ₅ (%)	Hardness
As Welded	>296	400	>6	200 HB

REDRYING 140°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E FeNi 60 N

E FENI 60 N 2,5 X 300MM	Packaging	KG/unit	EanCode
	Can	2,7	8720663420626
E FENI 60 N 3,2 X 350MM	Packaging	KG/unit	EanCode
	Can	3,5	8720663420633
E FENI 60 N 4,0 X 350MM	Packaging	KG/unit	EanCode
	Can	3,2	8720663420640