



CEWELD E Ni

TYPE	Pure nickel core elektrode special coated for welding cast iron.															
APPLICATIONS	CEWELD®E Ni is for joining and cladding gray and malleable cast iron, also suitable for joint welding between steel, copper and copper alloys, especially for maintenance and repair. Also for joining with steel, copper and monel. Areas of application are: Power generation industry, build-up welding and repairs, petrochemical and chemical industry, industry															
PROPERTIES	CEWELD®E Ni exhibits excellent welding properties with easily controllable flow behavior and enables spatter-free welding with very low current. Due to the very low heat input and the unique composition of Ni, the transition zone remains easily workable and is therefore well suited as the first layer in multi-layer welding. The weld metal has no bonding defects! Preheating is recommended to slow down the cooling rate, if you cannot control the cooling rate, it is better to keep the workpiece at a low temperature during welding and hammer immediately after welding.															
CLASSIFICATION	AWS A 5.15: E Ni-Cl EN ISO 1071: E C Ni-Cl-1															
SUITABLE FOR	Grey Cast Iron, EN 1561: EN-GjL-150, EN-GjL-200, EN-GjL-250, EN-GjL-300, EN-GjL-350, GG-15, GG-20, GG-25, GG-30, GG-35, GG-40, EN 1563: EN-GJS-400-15, EN-GJS-400-18, EN-GJS-450-10, EN-GJS-500-7, EN-GJS-600-3, EN-GJS-700-2 G GG-40, G GG-45, G GG-50, G GG-60, G GG-70, G GG-80															
	Malleable cast iron: EN GJMB 350 - ENGJMB 650															
APPROVALS	CE															
WELDING POSITIONS																
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table><thead><tr><th>C</th><th>Si</th><th>Mn</th><th>Ni</th><th>Fe</th></tr></thead><tbody><tr><td>0.6</td><td>0.5</td><td>0.6</td><td>Rem.</td><td>0.6</td></tr></tbody></table>						C	Si	Mn	Ni	Fe	0.6	0.5	0.6	Rem.	0.6
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MECHANICAL PROPERTIES	<table><thead><tr><th>Heat Treatment</th><th>R_{P0,2} (MPa)</th><th>R_m (MPa)</th><th>A₅ (%)</th><th>Hardness</th></tr></thead><tbody><tr><td>As Welded</td><td>>262</td><td>300</td><td>>3</td><td>160 HB</td></tr></tbody></table>						Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	As Welded	>262	300	>3	160 HB
Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness												
As Welded	>262	300	>3	160 HB												
REDRYING	140°C / 2 hr															
GAS ACC. EN ISO 14175																



CEWELD E Ni

E NI 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	3,5	8720663420589

E NI 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	3,5	8720663420572