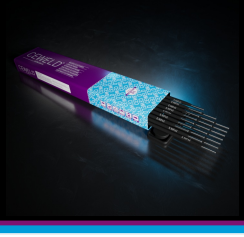


CEWELD E NiFe 2

certilas® THE FILLER METAL SPECIALIST

TYPE

Special “bimetal” core wire coated electrode for welding cast iron with high tensile strength.

APPLICATIONS

CEWELD® E NiFe 2 is suitable for welding gray and malleable cast iron, as well as ductile cast iron. Use this type when high tensile strength is required or because of its non-overheating coating. Also suitable for joining steel to cast iron!
For industrial applications such as:
Power generation industry, overlay welding and repairs
Construction and mechanical engineering, metallurgy (steelworks), mining, agriculture, lightweight construction.

PROPERTIES

CEWELD® E NiFe 2 offers several advantages compared to other “FeNi” grades due to improvements such as: weldable at very high current. The coating structure is not susceptible to overheating and produces a strong arc even at low amperages.
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 NiFe-CI
EN ISO	1071: E C NiFe-CI

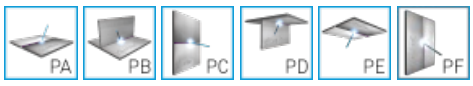
SUITABLE FOR

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
1.5	1.5	1	55	42

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	>296	400	>6	200 HB

REDRYING

140°C / 2 hr

GAS ACC. EN ISO 14175