

Descriptions

EQUIVALENT Cast 55Ni is a covered electrode with graphite type coating flux and Fe-Ni alloy rod. The weld metal provides low expansion coefficient, less hardening and good machining property. It is suitable for ductile cast iron, malleable cast iron and gray cast iron.

Notes on usages:

1. Strike the work piece and weld bead to prevent shrinkage stress.
2. Clean up the contaminations on the work piece.
3. Preheat the base metal at 300°C, PWH at 500 – 600°C.
4. Use small amperage and keep the arc as short as possible.

Classification

AWS A5.15 ENiFe-CI

JIS Z3252 DFCNiFe

EN EC NiFe-1-3

Typical Chemical Composition (All Weld Metal), weight %

C	Mn	Si	Al	S	Ni	Fe			
1.45	0.36	1.73	0.20	0.02	53.2	Rem			

Mechanical Properties (All Weld Metal, as welded)

Yield Strength, N/mm2	
Tensile Strength, N/mm2	490
Elongation, %	
Vicker's Hardness (HV)	170

Operating Data

Diameter	Length	AC/DC+
Ø 2.6mm	300mm	60-80
Ø 3.2mm	350mm	80-120
Ø 4.0mm	350mm	120-150