

NI-ROD[®] 55 Welding Electrode

NI-ROD 55 Welding Electrode is used for shielded-metal-arc welding of gray, ductile, malleable, and Ni-Resist cast irons. It is also used for welding cast irons to various wrought materials, including carbon steels, low-alloy steels, and nickel alloys. The electrode is especially useful for welding heavy sections and high-phosphorus irons.

The electrodes provide excellent operability for groove and fillet welding in the downhand position and the smaller diameter electrodes are also suitable for all position welding. Power supply: direct current, electrode positive.

Specifications

AWS A5.15 ENiFe-C1 (UNS W82002)

ASME II C SFA-5.15, ENiFe-C1 (UNS W82002)

*(EN) ISO 1071 – E C NiFe-C1

*Supply to these specifications available upon request

Approvals

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

| Typical Chemical Composition | Ni+Co | | S | |
|------------------------------------|-------------|---------|----------|-------|
| | C | 53.0 | Si | 0.005 |
| Mn..... | 1.20 | Cu..... | 0.70 | |
| Fe..... | 0.30 | | 0.10 | |
| | 45.0 | | | |

| Typical Mechanical Properties | Tensile Strength, psi | | 57,000-84,000 | |
|-------------------------------------|-----------------------|------|---------------|--|
| | | MPa | 393-579 | |
| | Elongation, (4d) % | 6-13 | | |

Available Product Forms – Supplied in 10lbs (4.54kg) hermetically sealed containers

| Diameter | mm in | 2.4 3/32 | 3.2 1/8 | 4.0 5/32 | 4.8 3/16 |
|----------|----------------|----------------|----------------|--------------------|--------------------|
| Length | mm in | 305 12 | 356 14 | 356 14 | 356 14 |
| Current | A DC+ AC | 50-70 55-65 | 75-95 70-85 | 110-130 110-125 | 135-170 135-150 |

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