

Cast Iron Ni-Fe Welding Electrode

NI-ROD[®] 55 Welding Electrode



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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, or alternating current.

Specifications

AWS A5.15 ENiFe-C1 (UNS W82002)
 ASME II, Part 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	53.0	S	0.005
	C	1.20	Si	0.70
	Mn.....	0.30	Cu.....	0.10
	Fe.....	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	50-70	75-95	110-130	135-170
	DC+ AC	55-65	70-85	110-125	135-150

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