

PROWELD Ni55 *For Cast Iron*

Classification

AWS A5.15 : ENiFe-CI
JIS Z3252 : DFCNiFe
DIN 8573 : E NiFe BG 22

Approvals

TIS

Applications

Welding of normal cast irons and ductile cast irons.

Characteristics

PROWELD Ni55 is a graphite type electrode. It's Fe-Ni composite wire assures no excessive heating of electrode and no change of operational characteristics during welding. Deposited metal shows excellent mechanical properties and crack resistance.

Typical Chemical Composition of Deposited Metal (%)

C	Si	Mn	P	S	Ni	Fe
≤1.0	≤1.0	≤1.0	≤0.020	≤0.020	48~65	Remainder

Typical Tensile Strength & Hardness of Deposited Metal

Tensile Strength N/mm ² (kgf/mm ²)	Vickers (HV)	Share	Heat Treatment
450 (46)	173	25	As welded

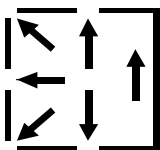
Size & Recommended Current Range (AC or DC+)

Diameter/Length(mm)	3.2/350	4.0/350	5.0/350
Welding Position	Current (A)		
All	100~140	150~180	190~230

Guideline in Usage

1. Use dry electrodes only. Damp electrodes should be re-dried at 80~120°C for 60 minutes before use.
2. Preheating and postheating are not necessary in general. However, preheating at 100-200°C is required for a structure which is apt to cause stress cracks.

Welding Positions



All positions, except vertical down

Because PROWELD is constantly improving products, PROWELD reserves the right to change specifications without notice.