YAWATA Ni Cast 55 *For Cast Iron*

Classification

AWS A 5.15 : ENiFe-CI
DIN 8573 : E NiFe BG 23

Approvals

TIS

Applications

Welding of normal cast irons and ductile cast irons.

Characteristics

YAWATA Ni Cast 55 is a graphite type electrode. Its Fe-Ni composit 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
≦1.0	≦1.0	≦1.0	≦0.020	≦0.020	48～65

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

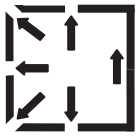
Sizes & Recommended Current Range (AC or DC +)

Diameter/ Length (mm)	2.6/300	3.2/350	4.0/350
Welding Position	Current (A)		
All	60～90	100～140	150～180

Guideline in Usage

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

Welding Positions



All positions, except vertical down