XTR Nickel 55

AWS A5.15 ENiFe-CI

Features & Applications:

Universal electrode for joining a wide variety of ductile, nodular and malleable cast irons. Ideally suited for the repair of meehanite dies. Non-overheating, hard driving, Ferro-Nickel electrode for penetrating dirty-rusty contaminated cast irons.

- Excellent for joining cast iron to steel
- Extremely strong arc drive penetrates surface contaminants
- Special slag composition can be welded over without creating porosity
- Extra nickel content insures crack resistant

Chemistry:

	Typical	AWS Spec. Single values are max. unless noted
Carbon (C)	1.900	2.000
Manganese (Mn)	2.300	2.500
Silicon (Si)	3.800	4.000
Sulfur (S)	0.030	0.030
Nickel (Ni)	56.500	45.0-60.0
Copper (Cu)	0.600	2.500
Aluminum (Al)	0.970	1.000

Mechanical Properties: (All weld metal analysis, Typical Weight %)

	Typical	AWS Spec. Single values are min.
Tensile Strength	64,000	58-64 ksi
Yield Strength	54,000	43-63 ksi
Elongation in 2" (%)	17	6-18
Hardness BHN	180	165-218

Microstructure	Consists of an iron-nickel austenite with finely distributed graphite
Flux Coating, Color	Black

Welding Positions:

F, V, OH, H

Operating Parameters: Coated Electrode/Rod (SMAW), DC Reverse (+), or AC

Formula: 1142

Procedures & results may vary with any change in position, equipment being used, base metal and base metal cleanliness.

Diameter	Amperage Range	Weldmetal Electrode	Electrodes per lb. (kg) of Weldmetal	Arc Time of Deposition min/lb. (kg)	Electrodes (Rods) per Lb. Packaged
1/16 **(1.6mm)**	--	--	--	--	--
5/64 **(2.0mm)**	--	--	--	--	--
3/32 **(2.4mm)**	50-80	.44 oz. (13g)	36 (80)	45 (100)	28
1/8 **(3.2mm)**	70-110	.76 oz (21g)	21 (47)	22 (49)	15
5/32 **(4.0mm)**	100-140	1.07 oz (31g)	15 (32)	20 (45)	10
3/16 **(4.8mm)**	130-175	1.6 oz (45g)	10 (22)	19 (42)	6
1/4 (6.4mm)	--	--	--	--	--

SCAN for SDS