



NI 55

DESCRIPTION: NI 55 is used for welding of cast irons to themselves as well as for joining cast irons to mild steels. IT is also employed for the repair of castings. The welds are moderately hard and require carbide tipped tools for machining. A preheat and inter pass temperature of not less than 350°F (175°C) is required during welding.

APPROVALS: Manufactured under Quality System approved by ASME, IS09001 Meets AWS A5.15, Class ENiFe-CI.

CHEMICAL COMPOSITION

Carbon	.9
Manganese	.74
Silicon	2.09
Iron	40.2
Copper	1.9
Nickel	54.5
Sulfur	.006
Phosphorus	.012

MECHANICAL PROPERTIES

Tensile Strength	
84,000 PSI	580 MPA
Yield Strength	
59,500 PSI	390 MPA
Elongation	
8%	

WELDING PARAMETERS

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.