

**SMAW**

# AceWeld 55Ni

## For Cast Iron

CLASSIFICATIONS: AWS A5.15 : ENiFe - Cl  
JIS Z3252 : DFCNiFe

WELDING POSITIONS :



- **Basic, Graphite Coating**
- **Machinable Nickel-Iron Deposit**

### DESCRIPTION AND APPLICATIONS

**AceWeld 55Ni** is a high grade special purpose electrode with ferro - nickel alloy core rod (Fe 45% Ni 55%). This electrode weld deposits gives extra strength and machineability.

**AceWeld 55Ni** features an extremely soft, smooth arc action with low spatter and minimal penetration on either AC or DC.

Suitable for welding of nodular cast iron, repairing and joining all kinds of cast iron. Also suitable for underlying of hardfacing.

### TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	P	S	Fe	Ni
1.26	0.80	0.66	0.005	0.003	Bal	57.25

### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES •

TENSILE STRENGTH	ROCKWELL
500 N/mm <sup>2</sup>	HrB 85 - 95

- in "as welded" condition.

### OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE • (amps.)	PACKAGING (KG)		
			PKT	CTN	
2.6	300	50 - 75	1	2.5	20
3.2	350	60 - 100	1	2.5	20
4.0	350	90 - 130	1	2.5	20

- Recommended for DC + or AC (minimum 45 OCV) operation