

**NI-ROD<sup>®</sup> 55 Welding Electrode**

**NI-ROD 55 Welding Electrode** is used for shielded-metal-arc welding of gray, ductile, malleable, and Ni-Resist cast irons. It is also used for welding cast irons to various wrought materials, including carbon steels, low-alloy steels, and nickel alloys. The electrode is especially useful for welding heavy sections and high-phosphorus irons.

The electrodes provide excellent operability for groove and fillet welding in the downhand position and the smaller diameter electrodes are also suitable for all position welding. Power supply: direct current, electrode positive, or alternating current.

**Specifications**

AWS A5.15 ENiFe-C1 (UNS W82002)

ASME II, Part C, SFA-5.15, ENiFe-C1 (UNS W82002)

\*(EN) ISO 1071 – E C NiFe-C1

\*Supply to these specifications available upon request

**Approvals**

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

**Typical Chemical Composition**

Ni+Co .....	53.0	S .....	0.005
C .....	1.20	Si .....	0.70
Mn.....	0.30	Cu.....	0.10
Fe.....	45.0		

**Typical Mechanical Properties**

Tensile Strength, psi	57,000-84,000
MPa	393-579
Elongation, (4d) %	6-13

**Available Product Forms** – Supplied in 10lbs (4.54kg) hermetically sealed containers

Diameter	mm in	2.4 3/32	3.2 1/8	4.0 5/32	4.8 3/16
Length	mm in	305 12	356 14	356 14	356 14
Current	A DC+ AC	50-70 55-65	75-95 70-85	110-130 110-125	135-170 135-150