

# Ni-cast 55 ENiFe-CI Tig Welding Wire

## DESCRIPTION

**ERNi-CI** (Nickel 55) welding electrode is designed for welding gray iron castings to themselves as well as joining them to mild steel. It can also be used to repair castings. The welds are moderately hard and require carbide tipped tools for post weld machining. A preheat and interpass temperature of not less than 177°C is recommended during welding. content, the welds are readily machinable. A preheat and interpass temperature of 350°F min is recommended during welding.

SHIELDING GAS: Argon/Helium Mixtures

WELDING CURRENT: DCEP

CONFORMANCES: ERNi-CI **AWS:** AWS A5.15-90 (R2006)

Typical Wire Chemistry as welded with 100% CO2 shielding gas

C	Mn	Si	S	Fe	Ni	Cu	Al	Other
2.0	2.5	4.0	0.03	REM	45-60	2.5	1.0	1.0

Mechanical Properties (As Welded)

Tensile Strength (MPa)	Yeild Strength (MPa)	Elongation (% Min)
579	407	8

WELDING POSITIONS: F,V,OH,H