



# Cast Iron Ni-Fe Welding Electrode

## NI-ROD® 55X Welding Electrode

18

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**NI-ROD 55X Welding Electrode** is a premium quality consumable for cast iron, offering true out-of-position welding capability with an ease of operation rivalling carbon steel electrodes. NI-ROD 55X Electrode has a nickel-iron core wire to produce strong welds with low residual shrinkage stresses, and is well suited for welding thick sections. It has high tolerance for phosphorus and other contaminants in the base metal, so high strength, good ductile welds can be made in low-grade cast irons.

NI-ROD 55X Welding Electrode is used for joining gray iron, ductile iron, compacted graphite iron, malleable iron and various alloyed irons to themselves, to each other, to steels, to stainless steels, and to nickel alloys.

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

For manufacture to ASME III (NCA3800, NB2400), and other specifications please refer your inquiry to the Technical Department prior to order placement.

### Approvals

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

### Limiting Chemical Composition

Ni .....	45-60	S .....	0.30 max.
C .....	2.0 max.	Si .....	2.0 max.
Mn .....	2.5 max.	Cu .....	2.5 max.
Fe .....	Remainder		

### Typical Mechanical Properties

Tensile Strength, psi	50,000-80,000
MPa	517
Elongation, (4d) %	15-20

### 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