

Cast Iron Nickel Welding Electrode

NI-ROD[®] Welding Electrode



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NI-ROD Welding Electrode is used for shielded-metal-arc welding of gray, ductile, and malleable cast irons. It is also used for joints between cast irons and carbon steel or low-alloy steel. The electrode is particularly useful for thin sections and for joints to be machined.

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 ENi-CI (UNS W82001)

ASME II, Part C, SFA-5.15, ENi-CI (UNS W82001)

*(EN) ISO 1071 – E C Ni-CI

*Supply to these specifications available upon request

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.

Typical Chemical Composition	Ni+Co	95.0	S	0.005
	C	1.0	Si	0.70
	Mn.....	0.20	Cu	0.10
	Fe	3.0		

Typical Mechanical Properties	Tensile Strength, psi	40,000
		MPa
	Elongation, (4d) %	4

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	50-80	80-130	100-170	120-190
	DC+ AC	60-90	90-140	140-190	150-200

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