



S. R. Industries

STAR ARC ENiFe-Cl

Nickel 55 (ENiFe-Cl) 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 350°F is recommended during welding.

AWS Specification : AWS A5.15-90 (R2006)

AWS Classification	ENiFe-Cl
Welding Current	DCEP
Typical Wire Chemistry	
C	2.0
Mn	2.5
Si	4.0
S	0.03
Fe	REM
Ni	45 - 60
Cu	2.5
Al	1.0
OTHER	1.0
Typical Mechanical Properties (As Welded)	
Yield Strength, ksi	43 - 63
Tensile Strength, ksi	58 - 84
Elongation%, min	6 - 8
Welding Positions	F,V,OH,H

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<i>Available Diameters and Operating Range in Amps</i>	
<i>3/32"</i>	<i>70 - 90</i>
<i>1/8"</i>	<i>100 - 135</i>
<i>5/32"</i>	<i>130 - 180</i>
<i>3/16"</i>	<i>190 - 220</i>

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