

55 Ni-Fe Flux-Cored Wire

ALLOY DESCRIPTION AND APPLICATION;

Flux Cored 55 is shelf-shielded filler metal designed for welding of ductile iron, gray cast iron, malleable cast iron and for steel to cast iron. The formation provides the needed graphite in the weld to ensure lower shrinkage stress and reduces the affect of heat affected zone cracking.

TYPICAL FCAW WELDING PROCEDURES; DCEP

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout
0.045	225-350	120-180	23-27	3/4-1"
1/16"	175-275	160-250	24-29	3/4-1 1/4"
3/32"	100-200	250-350	25-29	1-1 1/2"

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL UNDILUTED WELD METAL CHEMISTRY (%) AND WELD METAL PROPERTIES;

U.S. ALLOY 55-FCO		Typical	
Nickel	45.0-60.0	Tensile Strength (psi)	70-80,000
Manganese	3.0-5.0	Yield Strength (psi)	58,000 min.
Silicon	1.00 max	Elongation in 2"	10-15 %
Copper	2.00 max.		
Carbon	1.00 max		

AVAILABLE SIZES: TNF 55FCO= Spools of .045
 Other sizes available – please inquire

SPECIFICATIONS; WASHINGTON ALLOY



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