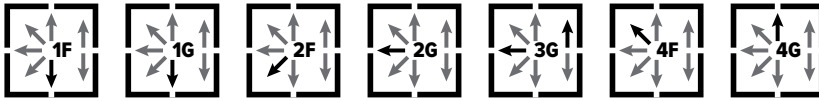


CAST IRON

HYPERARC  **ARC** Ni55



Summary

HYPERARC Ni55 are cast iron electrodes designed for welding and repairing grey cast iron components. They produce a moderately hard weld deposit that's more machineable than typical high nickel weld metals. These electrodes offer excellent fusion with cast iron, leading to reduced dilution and porosity. The welds have a graphite-rich structure, minimising the formation of brittle iron carbides, ensuring increased ductility.

Typical Applications

- Repair and rebuilding of grey cast iron
- Gearboxes and engine blocks
- Machine bases and frames
- Pumps and valve bodies
- Cast iron to steel welding

Classification

- AS/NZS 1553

Standards

- AWS A5.15 ENiFe-CI
- AWS/ASME SFA5.15: ENiFe-CI
- AS/NZS 1553: E-Ni55

Packaging Info

| SKU | ELECTRODE SIZE | WEIGHT | DESCRIPTION |
|--------|----------------|--------|---|
| U63028 | 2.6mm | 1kg | HYPERARC NI 55 CAST IRON ELECTRODES 2.6MM 1KG |
| U63029 | 3.2mm | 1kg | HYPERARC NI 55 CAST IRON ELECTRODES 3.2MM 1KG |

Operating Polarity

- AC & DCEP

Operating Data

| ELECTRODE SIZE | WELDING CURRENT RANGE |
|----------------|-----------------------|
| 2.6mm | 60A-90A |
| 3.2mm | 80A-120A |

Typical Chemical Composition (%)

| C | Mn | Si | P | S | Ni | Fe |
|-------|-------|-------|-------|-------|--------|-----|
| 0.570 | 0.590 | 0.720 | 0.005 | 0.002 | 55.200 | Rem |

Typical Mechanical Analysis

| | |
|-------------------------|-----|
| YIELD STRENGTH | 325 |
| TENSILE STRENGTH | 450 |