

NI-ROD[®] FC55 Flux Cored Wire

NI-ROD FC55 Flux Cored Wire is used for flux-cored-arc and submerged-arc welding of gray, malleable, and ductile cast irons. It is also used for surfacing of cast irons and for joining cast irons to various wrought materials such as carbon steels and low-alloy steels. The cored wire combines the desirable features of NI-ROD 55 Welding Electrode with the speed and economy of automatic or semi-automatic welding.

Submerged-arc welding with the cored wire is done with INCOFLUX 5 Submerged Arc Flux.

Specifications

AWS A5.15 ENiFeT3-CI (UNS W82032)

*(EN) ISO 1071 – T CI 5001 (T C NiFe-I)

*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	50.0	Mn	4.2
	C.....	1.0	Fe.....	44.0
	Si.....	0.6		

Typical Mechanical Properties	Tensile Strength, psi	69,000
	MPa	476
	Elongation, (4d) %	15.5

Available Product Forms

mm in	**1.14 0.045	**1.6 0.062	*2.4 0.093
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*0.093 on traverse wound 30 lb. masonite spools

**0.062 and 0.045 on level layer wound 30 lb. wire basket spools

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