



Product Data Sheet

Nicore 55

T 'Tubular cored electrode arc welding'

| | | | | | |
|--------------------------|---|--------------------|------------------------|------------------------|---------------|
| Signed by Neil Farrow | Approved by Neil Farrow/Christos Skodras | Reg no EN004425 | Cancelling PS000165 | Reg date 2008-07-09 | Page 1 (1) |
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REASON FOR ISSUE

A new specification

GENERAL

A cored wire designed for the welding of cast irons using with argon rich mixed gas.

Polarity: DC+

Alloy Type: Cast iron

CLASSIFICATIONS weld metal

Not applicable

APPROVALS

Not applicable

CHEMICAL COMPOSITION

All Weld Metal (%)

| | Min | Max |
|----|------|------|
| C | | 2.0 |
| Si | | 4.0 |
| Mn | | 1.0 |
| S | | 0.03 |
| Ni | 42.0 | 60.0 |
| Cu | | 2.5 |
| Al | | 1.0 |

ECONOMICS & CURRENT DATA

| Dimension (mm) | Current (A) | | W | η | H | | Feed | | U | |
|--------------------|-------------|-----|----|--------|-----|-----|------|-----|-----|-----|
| | Min | Max | | | Nom | Nom | Min | Max | Min | Max |
| \emptyset 1.2 | 220 | 250 | 20 | | | | | | 27 | 29 |

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)