



Product Data Sheet

T 'Tubular cored electrode arc welding'

Nicore 55

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								
$\emptyset$			Nom	Nom	Min	Max	Min	Max	Min	Max
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)