

GEMINI Ni 55

Typical Applications And Characteristics

GEMINI Ni 55 An all positional electrode depositing a 55% Ni/45 % Fe weld metal designed specially for strength welding. Grey cast iron and malleable cast iron with steel. Also designed to operate at low current which minimizes heat input and thus facilitates the “cold welding” of cast iron. Weld induced stresses can be reduced by hammer peening. Stable arc with clean bead appearance. The weld metal is fully machinable.

Typical All-Weld Metal Properties			
Composition (%)		Mechanical	
C	0.40	Yield strength	310 N/mm ²
Mn	0.45	Tensile strength	450 N/mm ²
Si	0.20	Vickers Hardness HV30	190 HB
Ni	55.00		

Typical welding current

AC or DC+				
Ø/L (mm)	2.6/300	3.2/350	4.0/350	5.0/350
Current min/max (A)	50/80	80/110	120/170	160/200

International Standard		Color	End	Green
AWS A5.15	E NiFe-C1	Coding	Side	Brown
ISO R 1071	E NiFe BG 22	Printing	G-Ni55/E NiFe-C1	
DIN 8573	E NiFe BG 1	Welding Positions	Flat, horizontal, vertical-up and overhead	