

GEMINI Ni 55

AWS/SFA5.15/E NiFe-CI

Typical Applications and Characteristics

GEMINI Ni 55 An all positional electrode depositing a 55% Ni/45 % Fe weld metal designed especially 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 | 0.44 | Yield strength | 310 N/mm ² |
| Mn | 0.73 | Tensile strength | 450 N/mm ² |
| Si | 0.80 | Elongation | 10 % |
| Ni | 54.00 | Vickers Hardness HV30 | 190 HV |

| AC or DC± | | | | |
|---------------------|---------|---------|---------|---------|
| ∅/L (mm) | 2.6X300 | 3.2X350 | 4.0X350 | 5.0X350 |
| Current min/max (A) | 50-80 | 80-110 | 120-170 | 160-200 |

| Typical welding current | | | |
|-------------------------|-------------------|--|-------|
| Approval | Color | End | Green |
| TIS. 732-2531 | Coding | Side | Brown |
| | Printing | G-Ni55/E NiFe-CI | |
| | Welding Positions | Flat, horizontal, vertical-up and overhead | |