

SMAW Electrodes – Cast Iron

GC55

AWS A5.15 ENiFe-CI
ISO 1071-ECNiFe-CI 1
JIS Z 3252 ECNiFe-CI N

Product Features:

- Graphite type nickel base covered electrodes for cast iron welding and repair.
- High welding performance and good arc stability in low current range.
- All deposited metal contains approximately 55% Ni, 45%Fe.
- Expansion coefficient is similar to cast iron, easy to machining.

Applications:

- Suitable for joint and repair welding of various kinds of cast irons.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni
1.00	1.08	0.43	55

Typical mechanical properties of all-weld metal

Hardness HV
200

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.6/300	3.2/350	4.0/350
Flat position	60~90	90~130	110~160

Note:

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