

TECH-ROD® 55

Nickel ▪ AWS ENiFe-CI

KEY FEATURES

- The welds are moderately hard and required carbide tipped tools for machining
- A preheat and inter-pass temperature of not less than 350°F is required during welding to prevent cracking
- Q2 Lot® - certificates showing actual deposit composition available online

CONFORMANCES

AWS A5.15/A5.15M: R2006 ENiFe-CI
UNS W82002

TYPICAL APPLICATIONS

- Welding cast irons
- Machine parts
- Repair of castings

DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	8 lb (3.6 kg) Can 24 lb (10.9 kg) Master Carton	10 lb (4.5 kg) Can 30 lb (13.6 kg) Master Can
3/32 (2.4)	12 (305)	EL55093632	
1/8 (3.2)	14 (355)		EL55125634
5/32 (4.0)	14 (355)		EL55156634

DEPOSIT COMPOSITION⁽¹⁾ - As Required per AWS A5.15/A5.15M: R2006

	%C	%Mn	%Si	%S	%Fe
Requirements AWS ENiFe-CI	2.0 max	2.5 max	4.0 max	0.03 max	Remainder
Typical Performance⁽²⁾ Tech-Rod® 55	1.3	0.4	1.0	0.003	—
	%Ni	%Cu	%Al	%Other	
Requirements AWS ENiFe-CI	45.0 - 60.0	2.5 max	1.0 max	1.0 max	
Typical Performance⁽²⁾ Tech-Rod® 55	50.0	1.0	0.5	—	

TYPICAL OPERATING PROCEDURES

Diameter in (mm)	Length in (mm)	Amperage	
		Flat	Vertical & Overhead
3/32 (2.4)	12 (305)	70-85	65-75
1/8 (3.2)	14 (355)	85-110	80-90
5/32 (4.0)	14 (355)	110-140	110-120

⁽¹⁾Typical all wire chemistry. ⁽²⁾See test results disclaimer on pg. 13.

Safety Data Sheets (SDS) are available on our website at www.lincolnelectric.com