

R-55FN

R-55FN is most Economical cast iron low heat input electrode.

Basis OF Alloys : C, Ni, Fe

Application & Descriptions : R-55Fn is most economical cast iron low heat input electrode. weld metal exhibits good strength and toughness. Weld deposits also offer good abrasion resistance. Nickel iron alloy weld metal which is easily machinable.

Suitable for repair and joining of cast iron parts of grey cast iron, malleable iron and nodular graphite iron. Filling up defects in casting. Typical applications include casing, impeller, engine head, rope drum, ingot moulds, bearing blocks, frames, foundry castings etc.

RE-DRY CONDITION : Re-Dry the electrode at 150°C for 1 hour,

ALL WELD MECHENICAL PROPERIES (TYPICAL):

UTS	HARDNESS
400 N/mm ²	AS WELDED 170 VPN

DIEMENSION, CURRENT CONDITION & PACKING DATA:

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/- AC) Amps	weight of packet (Kgs)	Weight of Case
2.50x350mm	3/32"X14"	50-80	2	20
3.20x350	1/8"X14"	70-110	2	20
4.00x350	5/32"X14"	100-130	2	20
5.00X350	3/16"X14"	130-160	2	20

Customer packing on request.