

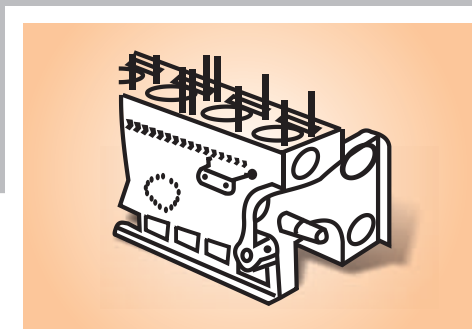
ESSEN® Cast 55 HL

AC/ DC +

Cast Iron electrodes For effective surface treatment

AWS A5.15-90 ENiFe CI, ASME SFA
5.15 A 96 E NiFe-CI

A Slagless Cast Iron Electrode for Very
High Recovery.



PROPERTIES

This is a Nickel-based electrode and is widely used to weld cast irons. Electrodes can be used for dissimilar joints, such as cast iron to carbon steel and nickel - based alloys. If the dissimilar joint uses cast iron welded to a chromium - containing steel, then a buttering layer of ESSEN CAST GH electrode should be used on the cast iron. This will help prevent the formation of chromium carbides in the weld deposit. Electrodes can be used to weld gray irons having high levels of phosphorous because the iron in the weld metal can tolerate phosphorus better than nickel.

MECHANICAL PROPERTIES

Tensile strength ~ 55,000 psi, Elongation : 10%

APPLICATIONS

Joining of dissimilar joints, cast iron to carbon steel and nickel base alloys, welding of gray iron castings such as sugar mill crusher rolls and where economical welding is desirable.

WELDING PROCEDURE.

Clean weld area free of grease, oil, etc. Preheat the area upto 250 C. Use a close arc to control the heat input. Peen to relieve the stresses. Maintain a constant weld temperature. Use a base layer of non machinable electrode like ESSEN CAST GH if it is required. Allow slow cooling.

RECOMMENDED AMPERAGE	
Size	Current
3.15mm x 350mm	110 - 160 Amps
4.00 mm x 350 mm	130 - 200 Amps

PACKING	
3.15 mm x 350 mm 5 kg	32 pcs/kg (Approx.)
4.00 mm x 350 mm 5 kg	21 pcs/kg (Approx.)



ESSEN
WELDING ALLOYS PVT. LTD.



ESSEN & AZUCAR
PREMIUM WELDING ALLOYS

ESSEN® PRODUCTS ARE MANUFACTURED AND SUPPLIED
ESSEN WELDING ALLOYS PVT. LTD. PUNE, INDIA,
TM REGISTERED IN INDIA BY: M/S. ASUGAR ENGINEERS PVT. LTD.
PUNE, VIDE REGD. T.M. NO. 543993 B.

'Sai maa', Post : Kadam Wak Wasti via Loni Kalbhori, Post P. B. No.1, Tal.: Haveli,
Dist.: Pune 412201, INDIA TEL: +91 -20 -65781493, 26911175 26911029 FAX: +91-20-26911030
Email: asugar@pn3.vsnl.net.in / essenelectrode@vsnl.net.in
Website: essenelectrode.com