

TECH-ROD 55

- I. **DESCRIPTION:** Tech-Rod 55 is used for welding of cast irons to themselves as well as for joining cast irons to mild steels. IT is also employed for the repair of castings. The welds are moderately hard and require carbide tipped tools for machining. A preheat and interpass temperature of not less than 350°F (175°C) is required during welding.
- II. **APPROVALS:** Manufactured under Quality System approved by ASME, ISO9001. Meets AWS A5.15, Class ENiFe-CI.

III. **CHEMICAL COMPOSITION**

Carbon	.9
Manganese	.74
Silicon	2.09
Iron	40.2
Copper	1.9
Nickel	54.5
Sulfur	.006
Phosphorus	.012

MECHANICAL PROPERTIES

Tensile Strength	
84,000 PSI	580 MPA
Yield Strength	
59,500 PSI	390 MPA
Elongation	8%

IV. **WELDING PARAMETERS**

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

V. **PACKAGES AVAILABLE:**

3/16"-10# can, 5/32"-10# can, 1/8"-10# Can, 3/32-8# can