

PRODUCT DATA SHEET

Afrox Transcast 55



Afrox Transcast 55 is an all-position electrode having a bimetal core wire and depositing a nickel iron alloy weld metal, which is machinable without undue difficulty. The weld metal after machining provides a close colour match with the casting. The low electrical resistance of the core wire avoids heat build-up in the electrode and ensures consistent arc and flux characteristics.

Applications

This electrode has been specifically developed for strength welding of high duty cast irons such as alloyed cast iron, meehanite, and malleable and nodular irons. It is ideal for welding various types of cast irons to each other or to steel.

It may also be used to weld high phosphorous castings and to join sections of grey iron to same or to ferrous materials. Although preheating is recommended, the consumable can be used without preheating the parent material.

Classifications

AWS	A5.15	ENiFe-CI
EN	1071	ENiFe-2

Typical Chemical Analysis (All weld metal)

% Carbon	2,0 max	% Iron	Bal.
% Manganese	1,0 max	% Nickel	45,0 - 60,0
% Silicon	4,0 max	% Copper	2,5 max
% Sulphur	0,03 max		

Packing Data

(DC+ AC 70 OCV min)

Diameter (mm)	Electrode Length (mm)	Current (A)	Pack Mass (kg)	Item Number
3,15	350	80 - 125	Sleeve (2 electrodes)	W072933
3,15	350	80 - 125	1,0	W072934
3,15	350	80 - 125	5,0	W075933
4,0	350	90 - 150	5,0	W075934

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