

Fe-Ni Type Electrode on Cast Irons (TIG Welding)

G N - 5 5 T

■ Tip Color Black

■ Application

Repair welding of cavities and cracks in a wide variety of cast iron parts.
Dissimilar metals welding, such as a mild steel and a cast iron.

■ Features

1. GN-55T is 45% Fe – 55% Ni type electrode on cast iron for TIG welding. It can use for cold welding. Also, its deposited metal shows excellent mechanical property. Expansion and contraction are limited hence it shows excellent resistance of cracking. These characteristics are suitable for welding thick material and parts which need strength.
2. GN-55T has excellent workability. Also, the heat-affected zone does not become too hard hence finishing process of this part is easy.

■ Welding Procedures

1. Preheating is not required. However if the occurrence of cracks are concerned 100~200°C preheating is suggested.

■ Typical Chemical Components of the Electrode (%)

C	Si	Mn	Fe	Ni
0.84	0.67	0.75	Remains	53.85

■ Typical Mechanical Properties of the Deposited Metal as welded

Tensile Strength N/mm ² (Kgf/mm ²)	480 (49.0)
Hardness	HV
	HRB
	HS

■ Dimensions

Diameter (mm)	Length (mm)	Minimum Quantity (Kg)
1.6 2.0 2.6 3.2	1,000	5

Equivalent to electrode for shielded metal arc welding: GRICAST31
 Equivalent to wire for MAG welding: GN-55SN