



Supplier of Welding Alloys

Nickel Alloy Coated Electrodes

Oxford Alloy® 55

SPECIFICATIONS

AWS 5.15
ASME SFA 5.15

CLASSIFICATIONS

AWS ENiFe-CI
UNS W82002

DESCRIPTION / APPLICATION

Oxford Alloy Nickel 55 is used for shielded-metal-arc welding of gray, ductile, malleable, and Ni-Resist cast irons. This electrode is also used for welding cast irons to various wrought materials, including carbon steels, low-alloy steels, and nickel alloys.

Oxford Alloy Nickel 55 is especially useful for welding heavy sections and high-phosphorus irons. The welds are moderately hard and require carbide tipped tools for machining. This electrode can be operated in all welding positions. The power supply is direct current; electrode positive is preferred although alternating current can be used.

AWS Chemical Composition						
Ni	C	Mn	Fe	S	Si	Cu
45.0-60.0	2.0 max	2.5 max	Bal	0.03 max	4.0 max	2.5 max
Al	OET					
1.0 max	1.0 max					

TYPICAL MECHANICAL PROPERTIES

Tensile strength: 71,050 psi 490 MPa
Yield strength: 52,925 psi 365 MPa
Elongation : 12%

Please contact our sales department for more information at 800-562-3355 or 225-273-4800.

Data contained in this publication are typical of the products and properties described, but are not suitable for specifications.
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