



Electrodes for Cast Iron | GEMINI Ni 55

GEMINI Ni 55 all positional electrode depositing a 55% Ni / 45% Fe weld metal designed specially for strength welding. Grey cast iron and malleable cast iron with steel. Also designed to operate at low current which minimizes heat input and thus facilitates the “cold welding” of cast iron. Weld induced stresses can be reduced by hammer peening. Stable arc with clean bead appearance. The weld metal is fully machinable.

TYPICAL ALL-WELD METAL PROPERTIES

COMPOSITION (%)		MECHANICAL	
C – Carbon	0.40	Yield strength	310 N/mm ²
Mn - Manganese	0.45	Tensile Strength	450 N/mm ²
Si - Silicon	0.20	Vickers Hardness HV30	190 HB
Ni - Nickel	55.00		

TYPICAL WELDING CURRENT

AC or DC +				
Diameter /Length (mm)	2.6/ 300	3.2/ 350	4.0/ 350	5.0/ 350
Current min/ max (A)	50/ 80	80/ 110	120/ 170	160/ 200

INTERNATIONAL STANDARD

MARKINGS & IDENTIFICATION

AWS A5.15	E NiFe-Cl	End Tip Colour	Green
ISO R 1071	E NiFe BG 22	End Side Colour	Brown
DIN 8573	E NiFe BG 1	Printing	G-Ni55/ E NiFe-Cl

WELDING POSITION

Flat, Horizontal, Vertical-up and overhead

PACKAGING & ORDERING INFORMATION

Size	Packet	Carton
2.6mm	1 kg	20 kgs
3.2mm	1 kg	20 kgs
4.0mm	1 kg	20 kgs
5.0mm	1 kg	20 kgs

Disclaimer: The information provided serves as a general guideline. Actual welding parameters may vary depending on the specific characteristics of the welding equipment. Additional variables to consider include weld length, plate thickness, operator proficiency, etc. Users are encouraged to assess their unique circumstances and seek professional advice as needed. It is important to acknowledge that neither we nor our affiliates can be held liable for any misuse or improper application of products.