DURAMAX NICKEL ALLOY ELECTRODE DMDURACLAD

Classification: **ENiFe** **AWS A 5.15 / ASME SFA 5.15**

Description, Characteristics & Applications:

DURAMAX DURACLAD NiFe one of a kind heavily copper clad "Tri-metal" cored cast iron electrode. the proprietary deposit chemistry yields the ultimate combination of softness, ductility and tensile strength.

DMDURACLAD NiFe electrode and its has a high disposition rate creates an extremely narrow heat affected zone, this feature is suitable for all weldable cast irons that require post weld machining.

Typical Chemical Composition (%)

AWS Spec.	C	Mn	Si	S	Fe	Ni	Cu	Al		
A5.15	2.0 max	2.5 max	4.0 max	0.03 max	REM.	45.0-60.0	7.0 max	1.0 max		
Typical	1.1	0.9	1.3	0.012	REM.	53.0	6.2	0.46		

Typical Mechanical Properties as Welded

Tensile Strength (n/mm²)	Yield Strength (n/mm²)	Elongation (%)
550	380	30

Typical Hardness as Welded

Rockwell	Brinell	Vickers
B 84-88	176	185

Typical Welding Parameters DCEP

Diameter	Type of Current	Amperage Range		Voltage Range
		Flat	Out of Position	
3/32"	DCEP	70 - 85	65 - 75	20 - 23
1/8"	DCEP	85 - 110	80 - 90	21 - 24
5/32"	DCEP	110 - 140	110 - 120	22 - 25
3/16"	DCEP	120 - 160	Not recommended	23 - 26

NOTE: Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

POLARITY: DCEP
DCEP: DC, Electrode Positive (reverse polarity) has the most weld penetration
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS