

## COR™MAIN 55 FC

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### DESCRIPTION

COR™MAIN 55 is a flux-cored, iron-nickel wire formulated to weld cast iron. A high carbon content promotes the formation of graphite in the weld metal, thus the shrinkage stresses and heat-affected zone cracking are minimized. This wire is available in gas shielded, self-shielded, and submerged arc formulations.

### APPLICATIONS

COR™MAIN 55 is used to join gray, ductile, and malleable cast iron components, and for joining steel to cast iron.

### PROCEDURE

Submerged arc welding requires a preheat/Interpass temperature of 550°F. Cool to room temperature. Post heat at 900°F for 3 hours. A post heat at 1150°F will enhance machining.

### WELDING PARAMETERS

Size	Volts	Amps	Stickout	Shielding Gas/Flux
MC-G .045"	19-21	120-150	1/2"	Ar-CO <sub>2</sub> Mixtures
MC-G 1/16"	20-23	150-220	1/2"	Ar-CO <sub>2</sub> Mixtures
FC-O .045"	23-26	120-150	1"	
FC-O 1/16"	24-27	160-220	1.25"	
FC-O 3/32"	24-28	250-350	1.5"	
FC-S 1/8"	34-37	250-350	1"	Lincoln 880

### MECHANICAL PROPERTIES

Tensile: 78,000 psi  
 Yield: 59,000 psi  
 Elongation: 10%  
 Area Reduction: 28%

### CLASSIFICATION

55% Ni, balance iron