

## NI-ROD<sup>®</sup> 99 Filler Metal

**NI-ROD 99 Filler Metal** is used for gas-metal-arc, gas-tungsten-arc and submerged-arc welding of ductile, malleable, and gray cast irons. It is a solid nickel alloy wire designed for making easily machined welds by automatic and semi-automatic processes. In highly diluted, single-layer deposits, pure nickel weld metal has better machinability than other welding products for cast irons. Submerged-arc welding is done with INCOFLUX 6 Submerged Arc Flux.

Disimilar-welding applications include gas-metal-arc welding of cast irons to low-alloy and carbon steels.

### Specifications

AWS A5.15 ERNi-CI (UNS N02215)

ASME II, Part C, SFA-5.15, ERNi-CI(UNS N02215)

\*BS 2901 NA46

\*(EN) ISO 5 CI 4003 (S C Ni-CI)

\*Supply to these specifications available upon request

For manufacture to ASME III (NCA3800, NB2400), and other specifications please refer your inquiry to the Technical Department prior to order placement.

### Approvals

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition	Ni+Co..... 99.0 min.		Cu..... 0.25 max.	
	Fe .....	0.40 max.	C.....	0.15 max.
Mn .....	0.35 max.	S.....	0.01 max.	
Si.....	0.35 max.	Others.....	1.00 max.	

Typical Mechanical Properties	Tensile Strength, psi		71,000
	MPa		490
	Elongation, (4d) %		12

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

### Available Product Forms

mm in	0.8 0.030	0.9 0.035	1.0 0.040	1.14 0.045	1.2 0.047	1.6 0.062	2.4 0.093	3.2 0.125
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Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)