

Ni-Rod FM 99

CATEGORY GMAW-GTAW Solid wires

TYPE Solid Nickel based filler metal for Mig welding.

APPLICATIONS Ni 99 is developed for welding ductile, grey and malleable cast irons. Ni 99 can also be used for dissimilar welding between cast iron and low alloyed steel or carbon steels.

PROPERTIES This Nickel weld deposit offers a easily machinable weld deposit with high ductility and no undercut.

CLASSIFICATION

AWS	5.15: ER Ni-CI
	UNS: N02215
EN ISO	1071: S CI 4003 (S C Ni-CI)
DIN	1736:

SUITABLE FOR Welding ductile, grey and malleable cast irons. Ni 99 can also be used for dissimilar welding between cast iron and low alloyed steel or carbon steels to prevent problems in the heat affected zone. (HAZ)

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	S	Fe	Others	Cu	Ni+Co
< 0.15	< 0.35	< 0.35	< 0.01	< 0.4	< 1.0	< 0.25	> 99.0

MECHANICAL PROPERTIES

Heat Treatment	RP0,2 N/mm2	RM N/mm2	Elongation (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				20°C	40°C	60°C	
AW	250	490	40				

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing (kg)	
D (mm)	Voltage (V)	Current (A) DC+	spool type	Weight
1.0	26-29	150-190	D-300	13.6
1.2	28-32	200-250	D-300	13.6

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: M11+25%He