

Ni-Rod FM 99 TIG

CATEGORY GMAW-GTAW Solid wires

TYPE Solid Nickel based filler metal for Tig 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	A 5.15 ER Ni-C1
	UNS: N02215
EN ISO	1071 S C1 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	Rp02 N/mm2	RM (MPa)	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

D (mm)	Welding Parameters	Packing (kg)	
		single	master
1.6 x 1000	Current (A) DC-	5	25
	50-80		
2.0 x 1000	70-110	5	25
2.4 x 1000	110-180	5	25
3.2 x 1000	150-250	5	25

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1