



CEWELD Ni-Rod FM 99

TYPE Pure Nickel welding wire for joining cast iron.

APPLICATIONS CEWELD Ni 99 FM 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: E Ni-CI
EN ISO 1071: E C Ni-CI-1

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

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Ni	Fe	Cu
0.15	0.35	0.35	0.01	0.01	Rem.	0.4	2

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	250	490	40	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 M11



CEWELD Ni-Rod FM 99

NI-ROD FM 99 1,2MM

Packaging	KG/unit	EanCode
BS-300	13,6	8720663417688