



CEWELD Ni-Rod FM 99 Tig

TYPE Pure nickel Tig filler metal for welding cast iron.

APPLICATIONS CEWELD® Ni-Rod FM 99 Tig 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. Welding ductile, grey and malleable cast irons. CEWELD® Ni 99 F 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.

PROPERTIES CEWELD® Ni-Rod FM 99 is designed for an easily machinable weld metal for automatic and semi-automatic applications. It delivers a pure nickel weld metal in highly diluted, single-layer deposits.

CLASSIFICATION AWS A 5.15: E Ni-Cl
EN ISO 1071: SC Ni-Cl

SUITABLE FOR Grey cast iron, malleable, nodular, dissimilar welding : NF A 32-101 : FGL 150, 200, 250, 300, 350, 400. NF A 32-201 : FGS 370-17, 400-12, 500-7, 600-3, 700-2. NF A 32-702 : MN 350-10, 380-18, 450-6, 350-4, 650-3. DIN 1691 : CG-14, 18, 25, 30. DIN 1693 : GGG-40, 50, 60, 70. DIN 1692 : GTS-35, 45, 55, 65, 70.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Ni	C	Mn	Fe	S	Si	Cu
Rem.	0.15	0.35	0.4	0.01	0.35	0.25

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	250	490	15	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 I1, M11



CEWELD Ni-Rod FM 99 Tig

NI-ROD FM 99 TIG 1,6MM	Packaging	KG/unit	EanCode
	Tube	5	8720663417855
NI-ROD FM 99 TIG 1,6 X 914MM	Packaging	KG/unit	EanCode
	Tube	4,54	8720663417862
NI-ROD FM 99 TIG 2,0 X 914MM	Packaging	KG/unit	EanCode
	Tube	4,54	8720663417879
NI-ROD FM 99 TIG 2,4 X 914MM	Packaging	KG/unit	EanCode
	Tube	4,54	8720663417886
NI-ROD FM 99 TIG 3,2 X 914MM	Packaging	KG/unit	EanCode
	Tube	4,54	8720663417893