



CEWELD Ni-Rod FM 99

TYPE	Pure Nickel welding wire for joining cast iron.						
APPLICATIONS	CEWELD® Ni 99 FM 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 99 FM 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 W.Nr.	A 5.15: E Ni-CI, 1071: SC Ni-CI UNS N02215					
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 (%)	C	Si	Mn	S	Ni	Fe	Cu
	0.09	0.35	0.35	0.01	Rem.	0.4	0.2
MECHANICAL PROPERTIES	Heat Treatment		R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	
	As Welded		250	490	12	HRc	
REDRYING	Not required						
GAS ACC. EN ISO 14175	M11						



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NI-ROD FM 99 1,2MM

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