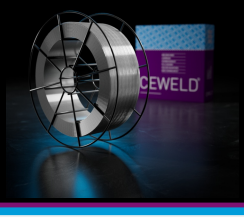


CEWELD Ni-Rod FM 99

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid Nickel based filler metal for MIG welding.

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.

PROPRIÉTÉS

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

CLASSIFICATION

AWS	A 5.15: E Ni-Cl, 1071: SC Ni-Cl
W.Nr.	UNS N02215

CONVIENT POUR

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.

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)

C	Si	Mn	S	Ni	Fe	Cu
0.09	0.35	0.35	0.01	Rem.	0.4	0.2

PROPRIÉTÉS MÉCANIQUES

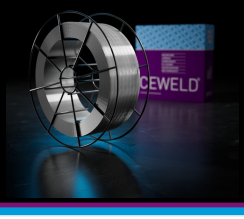
Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	250	490	12	HRc

ETUVAGE

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