



Cast Iron Filler Metal

NI-ROD[®] 99 Filler Metal

NI-ROD 99 Filler Metal is used for gas-metal-arc, gas-tungsten-arc and submerged-arc welding of ductile, malleable, and gray cast irons. It is a solid nickel alloy wire designed for making easily machined welds by automatic and semi-automatic processes. In highly diluted, single-layer deposits, pure nickel weld metal has better machinability than other welding products for cast irons. Submerged-arc welding is done with INCOFLUX NT100 Submerged Arc Flux.

Disimilar-welding applications include gas-metal-arc welding of cast irons to low-alloy and carbon steels.

Specifications

AWS A5.15 ERNi-CI (UNS N02215)

ASME II, Part C, SFA-5.15, ERNi-CI(UNS N02215)

*BS 2901 NA46

*(EN) ISO 1071 S CI 4003 (S C Ni-CI)

*Supply to these specifications available upon request

For manufacture to ASME III (NCA3800, NB2400), and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition	Ni+Co..... 99.0 min.		Cu..... 0.25 max.	
	Fe	0.40 max.	C.....	0.15 max.
Mn	0.35 max.	S.....	0.01 max.	
Si.....	0.35 max.	Others.....	1.00 max.	

Typical Mechanical Properties	Tensile Strength, psi		71,000
		MPa	
	Elongation, (4d) %		12

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

Available Product Forms

mm in	0.8 0.030	0.9 0.035	1.0 0.040	1.14 0.045	1.2 0.047	1.6 0.062	2.4 0.093	3.2 0.125
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Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)