



NI 99

DESCRIPTION: NI 99 is designed for welding of gray iron castings to themselves as well as joining them to mild steels or stainless steels. It is also used extensively to repair castings. The welds are quite machinable. A preheat and interpass temperature of not less than 350°F is recommended during welding

APPROVALS: Manufactured under Quality System approved by ASME, IS09001. Meets AWS A5.15, Class ENi-CI.

CHEMICAL COMPOSITION

Carbon	.85
Manganese	.25
Silicon	1.73
Iron	4.2
Copper	1.5
Nickel	91.50
Sulfur	.005
Phosphorus	.015

MECHANICAL PROPERTIES

Tensile Strength	
72,000 PSI	500 MPA
Yield Strength	
56,500 PSI	390 MPA
Elongation	5%

WELDING PARAMETERS

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.