Inweld Nickel 99

AWS A5.15 ENi-CI

Chemical Composition of Nickel 99

C	Mn	Si	P	S	Fe	Ni	Mo	Cu	Al	Other
2.0	2.5	4.0	---	0.03	8.0	85.0 min	---	2.5	1.0	1.0

Single values are maximum unless otherwise specified.

Description and Applications

Inweld 99 is used for TIG and MIG welding of cast iron. This wire is extensively employed to repair gray iron castings. It can also be used for overlay and buildup. However, dilution from the casting influences the mechanical properties of the metal. The welds are easily machine-able. A preheat and interpass temperature of 350ºF (175ºC) minimum is recommended during welding.

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	65,000 psi
Yield Strength:	35,000 psi
Elongation:	40%

Recommended Parameters

GMAW (DCEP – Electrode+)

Wire Diameter	Voltage	Amperage
0.035”		160-180
0.045”		180-220
1/16”		210-250

GTAW Unspecified

SMAW (DCEP – Electrode+)

Wire Diameter	Voltage	Amperage
3/32”		300-350
1/8”		400-550
5/32”		500-650