



# CEWELD Ni-Rod FM 99

**TYPE** Pure Nickel welding wire for joining cast iron.

**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.

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

**CLASSIFICATION** AWS A 5.15: E Ni-CI  
EN ISO 1071: E C Ni-CI-1

**SUITABLE 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 to prevent problems in the heat affected zone. (HAZ)

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	P	S	Ni	Fe	Cu
0.15	0.35	0.35	0.01	0.01	Rem.	0.4	2

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	250	490	40	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M11



# CEWELD Ni-Rod FM 99

NI-ROD FM 99 1,2MM

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