



CEWELD Ni-Rod FM 99

TYPE	Solid Nickel based filler metal for MIG welding.						
ANWENDUNGEN	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.						
EIGENSCHAFTEN	This Nickel weld deposit offers a easily machinable weld deposit with high ductility and no undercut.						
KLASSIFIKATION	AWS W.Nr.	A 5.15: E Ni-CI, 1071: SC Ni-CI UNS N02215					
GEEIGNET FÜR	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.						
ZULASSUNGEN							
SCHWEISSPOSITIONEN	PAPBPCPDPEPF						
TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)	C	Si	Mn	S	Ni	Fe	Cu
	0.09	0.35	0.35	0.01	Rem.	0.4	0.2
MECHANISCHE GÜTEWERTE	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	
	As Welded		250	490	12	HRc	
RÜCKTROCKNUNG	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