

# Inweld NI-99

AWS A5.15 ENi-CI

## Chemical Composition of Inweld NI-99

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

Single values are maximum unless otherwise specified.

## Description and Applications

Fully machine-able cast iron electrode for repair welding of thin sections. Excellent for build-up and joining cast iron to itself or to dissimilar metals including low alloy and carbon steel, stainless steel, iron and copper-nickel Monel alloys. High Nickel core of this electrode produces an arc that penetrates through dirt and oil as well as over slag. Weld deposits are relatively “soft” and can be milled, drilled, or tapped and the color will match that of cast iron. Common uses include engine blocks, machinery parts, frames, gears, and pulleys. Tensile strength up to 65,000 psi; Brinell hardness 170.

## Typical Weld Metal Properties

	<u>AWS Spec</u>
Average As-Welded Brinell Hardness:	170
Tensile Strength:	65,000 psi
Yield Strength:	40,000 psi
Elongation:	4%

## Recommended Parameters

SMAW

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
3/32"		30-70
1/8"		70-110
5/32"		90-130
3/16"		110-160

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