



CEWELD Ni-Rod FM 99 Tig

TYPE Solid Nickel based filler metal for TIG welding.

ANWENDUNGEN CEWELD® Ni-Rod FM 99 Tig is developed for welding ductile, grey and malleable cast irons. He 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	A 5.15: E Ni-CI
EN ISO	1071: SC Ni-CI

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



**TYPISCHE CHEMISCHE
ANALYSE DES
FÜLLMETALLS (%)**

Ni	C	Mn	Fe	S	Si	Cu
Rem.	0.15	0.35	0.4	0.01	0.35	0.25

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	250	490	15	HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175 I1, M11



CEWELD Ni-Rod FM 99 Tig

NI-ROD FM 99 TIG 1,6MM	Packaging	KG/unit	EanCode
	Tube	5	8720663417855
NI-ROD FM 99 TIG 1,6 X 914MM	Packaging	KG/unit	EanCode
	Tube	4,54	8720663417862
NI-ROD FM 99 TIG 2,0 X 914MM	Packaging	KG/unit	EanCode
	Tube	4,54	8720663417879
NI-ROD FM 99 TIG 2,4 X 914MM	Packaging	KG/unit	EanCode
	Tube	4,54	8720663417886
NI-ROD FM 99 TIG 3,2 X 914MM	Packaging	KG/unit	EanCode
	Tube	4,54	8720663417893