

Premium Nickle Arc Welding Electrodes

- Exceptional arc stability
- High strength nickel deposit
- All positional
- Welding of ductile cast irons
- Machinable deposits

Castweld 99 is a graphite nickel type electrode, used in repair and maintenance welding of cast irons. Its nickel filler material deposited metal shows excellent mechanical properties and crack resistance, a good colour match to most cast irons. Preheating and postheating may apply in some applications.

Current Type: AC or DC+

DIAMETER/LENGTH	2.5/300	3.2/350	4.0/350
Positions	Current(A)	Current(A)	Current(A)
All	50-80	70-110	110-150

Recommended for DC +/- or AC (minimum 50 OCV) Voltage is determined by arc current and electrode arc length.

Arc voltage shown is typical and is only to be used as a guide.

TYPICAL MECHANICAL PROPERTIES OF DEPOSITED METAL

Tensile Strength 430 MPa Vicker (Hv) 193 99% Ni

WELDING POSITIONS

All Positional Except Vertical Down



1G

2G

3G

4G

1F

2F

4F

CLASSIFICATION

AWS: A 5.15 ENi-CI

KEEP DRY Re-Drying/Conditioning temperatures of 300-350°C for 1 hour. Re-drying should be restricted to a maximum of three cycles.

Warning:

- Electric shock can kill
- Always wear eye protection
- Protect yourself and others around you
- Use enough ventilation for both arc and fume source
- Fumes and gases are dangerous to your health
- Arc rays can injure your eyes and burn-skin