

Cast Iron Nickel Welding Electrode

NI-ROD[®] 99X Welding Electrode

NI-ROD 99X Welding Electrode is a premium quality consumable for cast iron, offering true out-of-position welding capability with an ease of operation rivalling carbon steel electrodes. 99X Electrode has a commercially pure nickel core, and is recommended for welding thin cast iron sections and for where optimum machinability of single-pass or single-layer weldments is required.

NI-ROD 99X Welding Electrode is used for joining gray iron, ductile iron, compacted graphite iron, malleable iron and various alloyed irons to themselves, to each other, to steels, to stainless steels, and to nickel alloys.

The electrodes provide excellent operability for groove and fillet welding in the downhand position and the smaller diameter electrodes are also suitable for all position welding. Power supply: direct current, electrode positive, or alternating current.

Specifications

For manufacture to ASME III (NCA3800, NB2400), and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition	Ni		S	
	C	85.0 min.	Si	0.03 max.
Mn.....	2.0 max.	Cu	2.0 max.	
Fe.....	2.5 max.		2.5 max.	
	8.0 max.			

Typical Mechanical Properties	Tensile Strength, psi		55,000
	MPa		378
	Elongation, (4d) %		8

Available Product Forms – Supplied in 10lbs (4.54kg) hermetically sealed containers

Diameter	mm in	2.4 3/32	3.2 1/8	4.0 5/32	4.8 3/16
Length	mm in	305 12	356 14	356 14	356 14
Current	A DC+ AC	50-80 60-90	80-130 90-140	100-170 140-190	120-190 150-200

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