



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 EN ISO	A 5.15: E Ni-Cl 1071: SC Ni-Cl				
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 Rem.	C 0.15	Mn 0.35	Fe 0.4	S 0.01	Si 0.35 Cu 0.25
MECHANISCHE GÜTEWERTE	Heat Treatment As Welded		R _{p0,2} (MPa) 250	R _m (MPa) 490	A5 (%) 15	Hardness HRc
RÜCKTROCKNUNG	Not required					
GAS ACC. EN ISO 14175	I1, M11					



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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