

## N99

### Comparable specifications

ASME SFA A 5.15: ENi-CI

DIN 17740: Ni 99,2

BS 2901: Pt 5 NA 46

Werkstoff Nr.: 2.4066

### Description and applications\*

\* Illustrative, not-exhaustive list

This grade may be used for:

- joining of ordinary gray irons to themselves or to other ferrous and nonferrous materials;
- welding of castings where the welding stresses are not overly severe or where the phosphorus content of the iron is not high;
- welding of ductile or malleable iron;
- applications where maximum machinability of highly diluted filler metal is necessary.

### Weldable base materials\*

\* Illustrative, not-exhaustive list

Irons and low-alloy and carbon steels

### All-weld metal mech. properties\*

\* For reference only values

Tensile strength (Rm): 276 - 448 N/mm<sup>2</sup>

### Chemical composition\*

\* For reference only values

C	Mn	Si	S	Fe	Ni	Cu	Ti	Mg
max	max	max	max	max	99.60	max	max	max
0.08	0.35	0.15	0.005	0.25	min	0.15	0.10	0.15

### Standard packaging data\*

Welding process	Product type	Ø mm (inches)	Packing type	Weight kg (lbs)	Length mm (inches)
GMAW **	filler wire	0.80 - 1.20 (0.030 - 0.047)	spools BS300 / D300	15 (33)	n.a.
SMAW **	core wire for electrodes	1.60 - 5.00 (1/16 - 0.197)	wooden boxes	500 - 750 (1100 - 1650)	250 - 450 (10 - 18)

\* Other sizes and packing types are available upon request

\*\* GMAW: gas metal arc welding; SMAW: shielded metal arc welding

### Marking

The outside of each unit package is suitably labelled with at minimum the following data: grade, diameter, heat, lot no., classifications.

Customized labels are available upon request.

### Lot classification

All our productions fulfil the **Class S3** requirements acc. to EN ISO 14344.