

MIDALLOY ERNi-CI (FM99) BARE WIRE

CLASSIFICATION

- AWS 5.15 Class ERNi-CI / ASME SFA 5.15 Class ERNi-CI

DESCRIPTION

- MIDALLOY ERNi-CI nickel alloy bare wire is used for GMAW and GTAW welding.

APPLICATIONS

- MIDALLOY ERNi-CI nickel alloy bare wire is used for Mig and Tig joining of various cast irons.
- This alloy can also be used for overlay, build-up, and repair, where easily machinable welds are required.
- This alloy can also be used for dissimilar-welding for applications such as cast irons to low-alloy or carbon steels.
- A preheat and interpass temperature of 350°F minimum is recommended during welding.

TYPICAL CHEMISTRY

C	Mn	Si	Fe	Ni + Co
.01	.25	.05	.25	99.2
P	S	Mo	Cu	Mg
.001	.002	.02	.13	.01

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	70,000 PSI
YIELD STRENGTH	36,000 PSI
ELONGATION	40%

RECOMMENDED WELDING PARAMETERS

(See attached)

STANDARD PACKAGING

- TIG 10 lb. tube / 60 lb. carton
- MIG 30 lb. spool

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