MIDALLOY NI-MAX 99 COATED ELECTRODE

CLASSIFICATION

- AWS/SFA 5.15 Class ENi-CI
- UNS# W82001
- (EN) ISO 1071-ECNi-CI

DESCRIPTION

- Midalloy NI-MAX 99 coated electrode is an all-position coated electrode used for joining work pieces of various types of cast iron. Midalloy NI-MAX 99 will run on AC or DCRP current.

APPLICATION

- Midalloy NI-MAX 99 coated electrode is used for joining and repair welding for various types of cast irons, including nodular Iron.
- Midalloy NI-MAX 99 coated electrode is used for joining various types of cast iron to carbon steel and some Nickel base metals.
- Midalloy NI-MAX 99 coated electrode deposits can be machined.

TYPICAL CHEMISTRY

C	Cu	Ni	Mn	Si	P	S	Fe	Al
0.45	0.2	BAL	0.18	0.25	0.015	0.002	1.35	0.06

TYPICAL MECHANICAL PROPERTIES ALL WELD METAL

Tensile Strength	50,000 PSI
Deposit Hardness	200 BN

WELDING PARAMETERS

DIAMETER	VOLTAGE	AMPERAGE
3/32”	22-28	70-85
1/8”	21-28	85-110
5/32”	22-28	110-140

PREHEAT AND INTERPASS TEMPERATURES

Preheat depends on the type and design of the material being welded. Interpass temperature and cooling rates need to be controlled to assure proper welding. Normal preheats range from 60°F to 600°F and depends on base metal thickness and condition. Interpass is usually limited to 850° followed by slow cooling.

STANDARD PACKAGING

- 3/32” 8 lb. Can / 48 lb. Carton
- 1/8”, 5/32”, and 3/16” 10 lb. Can / 60 lb.Carton

3/2/17

Office and Corporate Warehouse
630 Axminister Drive
St. Louis, MO 63026 • 636-349-6000 • 800-776-3300
Fax 636-349-2240