



XTR Nickel 99

AWS A5.15 ENi-CI

Features & Applications:

Very soft machinable welds on all weldable cast irons. Especially suited for welding in deep recesses or close quarters due to the non-conductive flux coating. Soft very machinable high nickel cast iron electrode featuring a totally non-conductive flux coating.

- Unusually strong arc drive penetrates oil and grease easily
- Excellent for vertical up welding

Chemistry:

	Typical	AWS Spec.
Carbon (C)	1.880	2.000
Manganese (Mn)	2.460	2.500
Silicon (Si)	3.900	4.000
Sulfur (S)	0.030	0.030
Iron (Fe)	1.500	8.000
Nickel (Ni)	Bal.	85.000 (min)
Copper (Cu)	1.770	2.500
Aluminum (Al)	0.930	1.000



Mechanical Properties:

	Typical	AWS Spec.
Tensile Strength	55,000	45-65 ksi
Yield Strength	38,000	38-60 ksi
Elongation in 2" (%)	5	3-6
Hardness BHN	155	135-218
Microstructure	Austenitic nickel with finely distributed graphite flakes.	
Flux Coating, Color	Black	

Welding Positions:

F, V, OH, H

Operating Parameters: Coated Electrode/Rod (SMAW), DC Reverse (+), or AC

Formula: 1140

Procedures & results may vary with any change in position, equipment being used, base metal and base metal cleanliness.

Diameter	Amperage Range	Weldmetal Electrode	Electrodes per lb. (kg) of Weldmetal	Arc Time of Deposition min/lb. (kg)	Electrodes (Rods) per Lb. Packaged
1/16 (1.6mm)	--	--	--	--	--
5/64 (2.0mm)	--	--	--	--	--
3/32 (2.4mm)	70-90	.64 oz (18g)	22 (48)	44 (97)	22
1/8 (3.2mm)	80-120	.77 oz (21g)	21 (47)	21 (46)	13
5/32 (4.0mm)	130-160	1.07 oz (31g)	15 (32)	20 (45)	9
3/16 (4.8mm)	--	--	--	--	--
1/4 (6.4mm)	--	--	--	--	--



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