TECHALLOY® 99

Nickel ▪ AWS ERNi-CI

KEY FEATURES

- Welds produced are generally more machinable than a Tech-Rod® 55 deposit
- A preheat and inter-pass temperature of not less than 350°F (175°C) is required during welding on cast iron to minimize the potential for cracks
- Q2 Lot® - certificates showing actual deposit composition available online

CONFORMANCES

AWS A5.15/A5.15M: R2006	ERNi-CI
UNS	N02215

TYPICAL APPLICATIONS

- Used for welding of cast irons to other cast irons as well as for joining cast irons to mild steels and stainless steels
- Readily used for the repair of castings

WELDING POSITIONS

All

SHIELDING GAS

MIG 75% Ar / 25% He
TIG 100% Ar

DIAMETERS / PACKAGING

Diameter in (mm)	MIG 33 lb (15 kg) Steel Spool	MIG 250 lb (113.4 kg) Accu-Trak® Drum	TIG 10 lb (4.5 kg) Tube 30 lb (13.6 kg) Master Carton
0.035 (0.9)	MG99035667	MG99045684	
0.045 (1.1)	MG99045667		
3/32 (2.4)			TG99093638

WIRE COMPOSITION[1] - *As Required per AWS A5.15/A5.15M: R2006*

	%C	%Mn	%Si	%S	%Fe
Requirements AWS ERNi-CI	2.0 max	2.5 max	4.0 max	0.03 max	8.0 max
Typical Performance[2] Techalloy® 99	0.003	0.07	0.09	0.001	0.1
	%Ni	**%Cu**	**%Al**	**%Other**	
Requirements AWS ERNi-CI	85 min	2.5 max	1.0 max	1.0 max	
Typical Performance[2] Techalloy® 99	99	0.02	0.1	<0.50	

TYPICAL OPERATING PROCEDURES

Process	Diameter in (mm)	Voltage (volts)	Amperage	Gas
MIG	0.035 (0.9)	24-27	150-190	75% Argon / 25% Helium
	0.045 (1.1)	25-30	200-290	

[1]Typical all weld metal. [2]See test results disclaimer on pg. 13.
Safety Data Sheets (SDS) are available on our website at www.lincolnelectric.com

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

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