

TECH-ROD® 99

Nickel ■ AWS ENi-CI

KEY FEATURES

- Used for welding of cast irons to other cast irons as well as for joining cast irons to mild steels and stainless steels
- A preheat and inter-pass temperature of not less than 350°F is required during welding to prevent cracking
- Q2 Lot® - certificates showing actual deposit composition available online

CONFORMANCES

AWS A5.15/A5.15M: R2006 ENi-CI
UNS W82001

TYPICAL APPLICATIONS

- Generally more machinable than a Tech-Rod® 55 deposit
- Intended to join and repair casts

DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	8 lb (3.6 kg) Can 24 lb (10.9 kg) Master Carton	10 lb (4.5 kg) Can 30 lb (13.6 kg) Master Can
3/32 (2.4)	12 (305)	EL99093632	
1/8 (3.2)	14 (355)		EL99125634
5/32 (4.0)	14 (355)		EL99156634

DEPOSIT COMPOSITION⁽¹⁾ - As Required per AWS A5.15/A5.15M: R2006

	%C	%Mn	%Si	%S	%Fe
Requirements AWS ENi-CI	2.0 max	2.5 max	4.0 max	0.03 max	8.0 max
Typical Performance⁽²⁾ Tech-Rod® 99	1.5	0.6	0.2	0.002	3.0
	%Ni	%Cu	%Al	%Other	
Requirements AWS ENi-CI	85.0 min	2.5 max	1.0 max	1.0 max	
Typical Performance⁽²⁾ Tech-Rod® 99	94.0	0.1	0.1	-	

TYPICAL OPERATING PROCEDURES

Diameter in (mm)	Length in (mm)	Amperage	
		Flat	Vertical & Overhead
3/32 (2.4)	12 (305)	70-85	65-75
1/8 (3.2)	14 (355)	85-110	80-90
5/32 (4.0)	14 (355)	110-140	110-120

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