

AWS CLASSIFICATION

AWS A5.15-90, ENi-CI

DESCRIPTION

Stoody Castweld 99 is an excellent high nickel alloy material for the build up and the joining of cast iron, with it's deposits softer than the Stoody Castweld 55, for better machining.

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	3/32 (2.4)	1/8 (3.2)
Current, Amp. DCRP	40 – 80	70 – 110
Position	Flat	Flat
Length	9"	14"

Diameter, In. (mm)	5/32 (4.0)
Current, Amp. DCRP	100 – 140
Position	Flat
Length	14"

TYPICAL DEPOSIT CHARACTERISTICS

Deposit Layers	Unlimited
Machinable	Yes

STANDARD SIZES & PACKAGING

<u>Diameter</u>	<u>Packaging</u>	<u>Part #</u>
3/32" (2.4mm)	5# Vac Pak	11375100
1/8" (3.2mm)	10# Vac Pak	11375200
5/32" (4.0mm)	10# Vac Pak	11375300

TYPICAL DEPOSIT CHEMISTRY (wt%)

Carbon	0.9
Manganese	0.3
Nickel	Balance
Silicon	3.0
Copper	1.4

TYPICAL APPLICATIONS

Repairing of cast iron, building up and joining, particularly hairline cracks and casting defects.

Stoody Company

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