


**99/99 BF** AC/DC±

**CAST IRON**

### DESCRIPTION

**Economical** pure nickel type electrode (Ni 99) for joining grey, malleable and nodular cast iron. Excellent for buttering before using a ferro-nickel type electrode. The **BF** version is **barium free** and the coating is non conductive.

### CHARACTERISTICS

- **Excellent machinability**
- Porosity free deposit
- All position weldability
- Low spatter
- Excellent anchorage of deposited metal
- Conforms to standard AWS A5.15 : ENi-CI

### TYPICAL APPLICATIONS

Ideal for rebuilding cast iron parts and for joining thin parts. Machinable errors, head of engine, cylinder chamber, transmission box, reducers, cast parts. Recommended for sealing joints.

### PROCEDURE

Clean weld area removing dirt and all impurities. Bevel with **Soudotec 212 SP** or **Soudotec G12**. Use hot or cold welding technique (p.01-02 and 01-03). Keep a short arc. Do not wave. Peen each bead for stress relief. Let cool slowly.

### MECHANICAL PROPERTIES

Tensile strength: 50 000 psi (350 MPa)  
Hardness: 180 BH

### WELDING PARAMETERS

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	120 - 150 A	90 - 110 A	50 - 80 A

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*Specialized welding alloys and technology. For technical assistance or for ordering:*