

**HARRIS PRODUCTS GROUP**  
**4501 QUALITY PLACE**  
**MASON, OHIO 45040**  
**TEL. (513) 754-2000**  
**FAX, (513) 754-8778**  
[www.harrisproductsgroup.com](http://www.harrisproductsgroup.com)



## **NICKEL 99**

**I. DESCRIPTION:** Nickel 99 is designed for welding of gray iron castings to themselves as well as joining them to mild steels or stainless steels. It is also used extensively to repair castings. The welds are quite machinable. A preheat and interpass temperature of not less than 350°F is recommended during welding

**II. APPROVALS:** Meets AWS A5.15, Class ENi-CI.

### **III. CHEMICAL COMPOSITION MECHANICAL PROPERTIES**

Carbon .85

Manganese .25

Silicon 1.73

Iron 4.2

Copper 1.5

Nickel 91.50

Sulfur .005

Phosphorus .015

#### **Tensile Strength**

72,000 PSI 500 MPA

#### **Yield Strength**

56,500 PSI 390 MPA

**Elongation 5%**

### **IV. WELDING PARAMETERS**

Direct Current

Electrode +

#### **AMPERAGES:**

3/32" 65-75

1/8" 90-105

5/32" 120-135

3/16" 135-155