

GEN 99 Welding Wire and Rod

GEN 99 is used for GMAW and GTAW welding of cast iron. While the wire is primarily used to repair gray iron castings, it is also used for overlay and buildup. A preheat and interpass temperature of 350°F (175°C) minimum is recommended during welding.

CONFORMANCES

AWS A5.15 : ERNiCl
ASME SFA-5.15 : ERNiCl
UNS : N02215

AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Mn	%Ni	%Cu
1.0 max	2.5 max	90 min	4.0 max
%Si	%Fe	%S	Total Others
0.75 max	4.0 max	0.03max	1.0 max

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength : 35,000 psi
Tensile Strength : 67,500 psi
Elongation : 40 %

TYPICAL WELDING PARAMETERS*

Process	Diameter	Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	14 – 18	90 – 130	100% Ar
	3/32"	15 – 20	120 – 175	100% Ar
	1/8"	15 – 20	150 – 220	100% Ar
MIG (GMAW)	.035"	29 – 33	160 – 180	75% Ar – 25% He
	.045"	29 – 33	180 – 220	75% Ar – 25% He
	.062"	29 – 33	200 – 250	75% Ar – 25% He

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

<p>IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.</p>
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