



Supplier of Welding Alloys

## Nickel Alloy Coated Electrodes

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### Oxford Alloy® 99

**SPECIFICATIONS**

AWS 5.15  
ASME SFA 5.15

**CLASSIFICATIONS**

AWS ENi-CI  
UNS W82001

**DESCRIPTION / APPLICATION**

Oxford Alloy Nickel 99 is used for shielded-metal-arc welding of gray, ductile, and malleable cast irons. This electrode is also used for joints between cast irons and carbon steel or low-alloy steel. Oxford Alloy Nickel 99 is useful for thin sections and for joints to be machined. The welds are quite machinable. This electrode can be operated in all welding positions. The power supply is direct current; electrode positive is preferred although alternating current can be used.

AWS Chemical Composition						
Ni	C	Mn	Fe	S	Si	Cu
85.0 min	2.0 max	2.5 max	8.0 max	0.03 max	4.0 max	2.5 max
Al	OET					
1.0 max	1.0 max					

**TYPICAL MECHANICAL PROPERTIES**

Tensile strength: 52,490 psi 362 MPa  
Yield strength: 49,010 psi 338 MPa  
Elongation: 5%

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Please contact our sales department for more information at 800-562-3355 or 225-273-4800.

Data contained in this publication are typical of the products and properties described, but are not suitable for specifications.  
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