



Supplier of Welding Alloys

Nickel Alloy TIG, MIG and SUB-ARC Wire

Oxford Alloy® 99

SPECIFICATIONS

AWS 5.15
ASME SFA 5.15

CLASSIFICATIONS

AWS ERNiCl
UNS N02215

DESCRIPTION / APPLICATION

Oxford Alloy Nickel 99 is used for the welding of cast irons. This filler metal is extensively employed to repair cast irons. It can also be used for overlay and buildup. However, dilution from the castings influences the mechanical properties of the metal. The welds of the Oxford Alloy Nickel 99 are easily machinable. A preheat and interpass temperature of 350°F (175°C) minimum is recommended during welding.

AWS Chemical Composition						
C	Mn	Si	Ni	S	Fe	Cu
1.0 max	2.5 max	0.75 max	90.0 min	0.03 max	4.0 max	4.0 max
OET						
1.0 max						

TYPICAL MECHANICAL PROPERTIES

Tensile strength: 66,500 psi 460 MPa
Yield strength: 36,000 psi 250 MPa
Elongation: 40%

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

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