



TECHNICAL INFORMATION SHEET

HARRIS 99 NICKEL TIG ROD

PRODUCT INFORMATION:

Nickel-Iron alloy electrode (AC-DC). A general purpose, nickel-iron electrode for production, salvage and repair of all cast irons.

TYPICAL AS WELDED MECHANICAL PROPERTIES:

Tensile Strength: Up to 70,000PSI
Yield Strength: Up to 80,000 PSI
Elongation: 18% minimum

GENERAL WELDING PROCEDURE:

- AC or DC reverse or straight polarity
- Hold a short arc
- Clean the weld area
- Run stringer beads
- Bevel breaks and cracks
- Skip or back-step weld
- Bevel deep enough so the first pass ties
- Peen to relieve stresses in the bottom of the crack
- Slow cool
- Preheating is typically not necessary
- Preheat heavy sections to approximately 4000F

SPECIFICATION COMPLIANCE:

Conforms to Harris Internal Specifications

SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.

ARC RAYS can injure eyes and burn skin.

FUMES AND GASES can be hazardous to your health.

HEAT RAYS, (infrared radiation) from flame or hot metal can injure eyes.

ELECTRIC SHOCK can kill.

- Before use, read and understand the manufacturer's instructions, Safety Data Sheets (SDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

WARNING: This product contains or produces a chemical known to the State of California to cause cancer and birth defects, (or other reproductive harm).

STATEMENT OF LIABILITY- DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

THE HARRIS PRODUCTS GROUP

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Additional information is available at our web site: www.harrisproductsgroup.com