



TECHNICAL INFORMATION SHEET

HARRIS NLW-99 STICK ELECTRODES

NIC-L-WELD 99

General purpose, high nickel alloy electrode for production and repair of cast iron

Applications:

Building up, joining, filling holes, breaks and cracks in all types of cast iron

Procedure:

- AC or DC reverse or straight polarity
- Clean the weld area
- Use CHAMFER ARC (pg. 50) to bevel breaks and cracks
- Bevel deep enough so the first pass ties in the bottom of the crack
- Preheating is typically not necessary
- Preheat heavy sections to approximately 400°F.
- Hold a short arc
- Run stringer beads
- Skip or back-step weld
- Peen to relieve stresses
- Slow cool

Features:

- Tensile strength - Up to 50,000 psi
- Excellent machinability
- All position
- Close color match
- Conforms to AWS A5.15, ENiCl

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

FUMES AND GASES can be hazardous to your health.

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

- 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 flame, or heat source, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- 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.

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