



## TECHNICAL INFORMATION SHEET

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### HARRIS NLW-59 STICK ELECTRODES

#### NIC-L-WELD 59

General-purpose nickel-iron alloy electrode for production, salvage and repair of all cast iron

#### Applications:

- Joining, filling & buildup of cast irons
- Pump housings
- Valves
- Castings
- Cast and malleable fittings
- General repair of all cast irons

#### Procedure:

- AC or DC reverse polarity
- Use CHAMFER ARC (pg. 50) or grinding to vee out cracks
- Preheat heavy castings to approximately 400°F
- Direct the arc upon deposited metal
- Hold electrode at a slight angle in the direction of travel
- Skip or back-step weld
- Lightly peen between passes
- Slow cool

#### Features:

- Tensile strength - Up to 70,000 psi
- Good machinability
- Close color match
- Conforms to AWS A5.15, ENiFeCl

**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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