

<p><b><u>Specifications:</u></b></p> <p>AWS A5.15 ERNi-CI</p>	<p><b><u>Properties (Typical):</u></b></p> <p><b>Tensile Strength:</b> 45-70 ksi  <b>Yield Strength:</b> 36-50 ksi  <b>Elongation in 2":</b> 6-12  <b>Reduction of area:</b> 20</p>
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**Description:**

WT 23-99 is available as TIG or MIG and is primarily used for automatic and semi-automatic welding of ductile, malleable cast iron to itself or dissimilar metals. Weld deposits are strong, dense and fully machinable. It is excellent for buildup of worn parts, repairing machining errors or defective castings. Use DC- (straight polarity) in TIG applications, with the oscillating technique and DC+ (reverse polarity) in MIG applications, with the stringer bead technique.

Available in multiple sizes and diameters

**Chemical Composition (Wt%):**

C	Mn	Si	S	Fe	N	Cu
1.0	2.5	0.75	0.03	4.0	90 min.	4.0

Note: Single values are maximum unless otherwise noted.

**Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.**

**CAUTION:** Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.