



TIGFIL Ni-1

GTAW NICKEL ALLOYS

AWS A/SFA 5.14 **ERNi-1**

CLASSIFICATION:

EN ISO 18274
SNi 2061 (NiTi3)

KEY FEATURES:

- A low carbon 96Ni/3Ti Nickel wire
- Almost pure Ni deposit
- Extremely strong and ductile weld metal
- Resistant to cracking and oxidation
- Low iron level ensure maximum corrosion resistance
- Radiographic weld quality

TYPICAL APPLICATIONS:

- Welding of wrought and cast form of commercially pure Ni (99.5%)
- Welding of Nickel 200 and 201
- Suitable for ASTM B160/161/162/163
- For dissimilar welding between Nickel 200/201 and various iron-base and nickel-base alloys
- Applications in Pumps and valves, Cryogenics, Chemical plants, Caustic handling equipments, Food processing equipments
- Overlay on carbon and low alloy steel
- Used for handling corrosive alkalis and halides



CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Fe	Si	Cu	Al	Ti	Ni
0.15 max	1.0 max	1.0 max	0.75 max	0.25 max	1.5 max	2.0-3.5	93.0 min

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	380	30

PARAMETERS - PACKING DATA:

Ø, mm	Net Wt., Kg		
2.0 x 1000	20	 DCEN STORAGE / HANDLING : Keep dry during storage and handling	All Positions 
2.4 x 1000	20		
3.15 x 1000	20		

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

Available in Standard carton packing of 20 kg box, containing 4 plastic tubes of 5 kg each.