MIG NI61

Classification

ISO 18274 : S-Ni 2061 (NiTi3) AWS A5.14 : ERNi-1

Description & Applications

Solid wire for GMAW of pure Nickel grades types like Alloy 200, Ni201, Ni99.2, LC-Ni99. Also use in heterogeneous welding of steel on Nickel ou Copper-Nickel alloys.

Main applications: Chemical and petrochemical industries, sub assembly layers

Base materials:

UNS	Alloy	DIN	Material N°
N02200	200	Ni99.2	2.4066
N02201	201	LC-Ni99	2.4068
N02205	205	LC-Ni99.6	2.4061
		Ni99.6	2.4060

Typical Chemical Composition (%)

	C	Si	Mn	Cu	P	S	Fe	Al	Ti	Ni
Min									2.0	93.0
Max	0.15	0.7	1.0	0.25	0.03	0.015	1.0	1.5	3.5	
Type	0.02	0.20	0.30	0.10	0.010	0.005	0.10	0.10	3.3	>93.0

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	-	-	-	-	-
Max					
Type	350	540	40	+20°C	250

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8 1.0 1.2 1.6	70 - 180 80 - 220 150 - 320 220 - 380	18 - 26 18 - 28 22 - 32 24 - 34	ISO 14175: I1 (100% Ar) I3 (Ar+10-30%He) Z (Ar+He+H+CO_2) 15-20 l/min

FT En-MI04-200901