



TIG NI61

Old reference: TIG NiTi4

Classification

AWS A5.14 : ERNi-1

ISO 18274 : S Ni 2061 (NiTi3)

Description & Applications

Solid rod for GTAW 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	0.030	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	Shielding Gas
TIG = -	ISO 14175: I1 (Ar) : 6-12 l/min Back shielding : I1 (Ar) : 3-6 l/min

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