Selectarc NiTi3

Pure Nickel Electrode

Classification

AWS A5.11 : ENi-1
Material N° : 2.4156

ISO 14172 : E-Ni 2061 (NiTi3)

Description & Applications

Basic coated electrode with a Nickel deposit containing 1-2%Ti designated for butt welding of pure Nickel (alloy 200) and surfacing of Nickel-copper, Copper-Nickel and Copper-Nickel plated steels. Also recommended for dissimilar joining like steels to Nickel-Copper or steel / Copper to Copper-Nickel. Excellent resistance to NaOH up to 400°C.

Main applications: Construction of equipment for the chemical industry and petrochemical industry, food stuff industry. For caustic soda production as well as for soap and detergents.

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 Weld Metal Composition (%)

C	Si	Mn	Fe	Ti	Al	Ni
<0.03	0.7	0.3	0.3	1.6	0.3	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>280	>420	>28	+20°C >160 -196°C >160

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	70-90	90-120	120-160

Redrying 1 h at 250-300°C. Joints to weld must be clean, exempt from grease, cracks. Guide electrodes with a slight declination (10-20°) inclined in direction of travel), weld with a short arc and apply the stringer bead technique (weaving max. 2 times core wire diameter). To improve degassing of the deposit, adopt a low welding speed.

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