TIG NI61
(TIG NiTi4)

Classification

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

Description & Applications

Solid rod for TIG welding of Nickel alloys like Ni 200 and 201, UNS N02200 and N02201, Ni99.2 and LC-Ni99. Lining of steel; welding of steel to Nickel and Nickel-Copper alloys.

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	Fe	Ti	Cu	P	S	Ni
0.02	0.2	0.3	0.1	3.3	0.1	<0.01	<0.01	Rem.

All Weld Metal Mechanical Properties

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

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon : 3-6 l/min

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