

Ni-base solid wire

Classification

AWS A5.14/A5.14M-97 : ERNi1

ISO 18274-01 : S Ni 2061 (NiTi3)

General description

Solid wire for welding pure nickel and nickel alloys and joining these materials with unalloyed/low-alloyed steel
Suitable for surfacing carbon steels

Shielding gases (acc. EN 439)

| | | |
|-----------|----|-------------------------|
| GTAW/GMAW | I1 | Inert gas Ar (100%) |
| | I3 | Inert gas Ar+ >0-95% He |

Approvals

| | |
|------|-----|
| | TÜV |
| GMAW | + |

Chemical composition (w%), typical, wire / rod

| C | Mn | Si | Ni | Ti | Fe |
|------|-----|-----|------|-----|------|
| 0.02 | 0.4 | 0.2 | bal. | 3.1 | 0.06 |

Mechanical properties, typical, all weld metal

| | Process | Shielding gas | Condition | 0.2% Proof strength (N/mm ²) | Tensile strength (N/mm ²) | Elongation (%) | Impact ISO-V(J) +20°C |
|----------------|---------|---------------|-----------|--|---------------------------------------|----------------|-----------------------|
| Typical values | GTAW | I1 | AW | 250 | 460 | 30 | 120 |
| | GMAW | I1 | AW | 250 | 460 | 30 | 120 |

Materials to be welded

| DIN-classification | W.Nr. | ASTM/ACI |
|--------------------|--------|-----------|
| Ni 99.6 | 2.4060 | |
| Ni 99.8 | 2.4050 | |
| Ni 99.6Si | 2.4056 | |
| Ni 99.4Fe | 2.4062 | |
| Ni 99.2 | 2.4066 | Alloy 200 |
| LC-Ni 99 | 2.4068 | Alloy 201 |
| LC-Ni 99.6 | 2.4061 | Alloy 205 |
| NiMn 10 | 2.4108 | |
| NiMn 5 | 2.4116 | |

Packaging

| Process | Unit | Sizes (mm) | | |
|---------|-------------------|------------|-----|-----|
| | | 1.2 | 2.0 | 2.4 |
| GTAW | 2 and 10 kg tube | | X | X |
| GMAW | 15 kg spool BS300 | X | | |

Other sizes and packaging on request

LNT/LNM NiTi: rev. EN 15

Liability: All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request