



NICALLOY 1

NON FERROUS (Ni Alloys)

AWS A/SFA 5.11 ENi-1

CLASSIFICATION:

ISO 14172

E Ni 2061 (NiTi3)

IS 8736

E Ni-1

KEY FEATURES:

- Basic type coating
- Low carbon pure Ni deposit
- Medium penetration weld
- Extremely strong and ductile weld metal
- Resistant to cracking and oxidation
- Low iron level ensure maximum corrosion resistance
- Positional welding capability

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of wrought and cast form of commercially pure Ni (99.5%)
- Welding of Nickel 200 and 201
- Suitable for ASTM B160/161/162/163
- For dissimilar welding between Nickel 200/201 and various iron-base and nickel-base alloys
- Overlay on carbon and low alloy steel
- Applications in Refineries, Heat exchanger, Pressure vessel, Pumps and valves, Cryogenics, Chemical plants, Caustic handling equipments, Food processing equipments
- Used for handling corrosive alkalis & halides


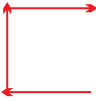
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Fe	Ni	Al	Ti
0.03	0.4	0.75	0.35	96.65	0.025	1.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	410 min	20 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	45 - 70	 DCEP All Positions, except vertical Down  REDRYING CONDITION: 250-300°C for minimum 1 hr.
3.15 x 350	80 - 100	
4.0 x 350	90 - 130	

Available in packing of 10 kg box containing 10 plastic cartons of 1 kg each.