



NICALLOY 1

NON FERROUS (Ni Alloys)



Coated stick Electrode depositing almost pure nickel

CLASSIFICATION : ISO 14172

AWS A/SFA 5.11

E Ni 2061 (NiTi3)

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

WELDING POSITION :



DCEP

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

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Ni	Fe	Ti
Specification	0.10 max	0.75 max	1.25 max	92.0 min	0.75 max	0.30-1.0
	S	P	Cu	Al	Ti	Other
Specification	0.02 max	0.03 max	0.25 max	1.0 max	1.0 to 4.0	0.50 max

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	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.5 x 350	45 - 70	1	10	10
3.15 x 350	80 - 100	1	10	10
4.0 x 350	90 - 130	1	10	10

EQUIVALENT : GMAW wire: Automig Ni-1

GTAW filler: Tigfil Ni-1