



MIG NI61

Old reference: MIG NiTi4

Classification

ISO 18274 : S-Ni 2061 (NiTi3) Material N° : 2.4155
 AWS A5.14 : ERNi-1

Description & Applications

Solid wire for GMAW of Nickel alloys. Used for lining of steel; welding of steel to Nickel and Nickel-Copper alloys.

Main applications: Energy and chemical industries.

Base material:

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	Al	P	S	Ni
0.02	0.2	0.3	0.1	3.3	0.1	0.15	<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	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	80-140	23-27	Ar Ar + He Ar/He + 0.05% CO ₂ 18-20 l/min
	1.0	90-160	24-28	
	1.2	160-200	24-28	
	1.6	180-260	24-28	

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