



### Characteristics and scope of application

- Filler metal for Ni alloys of the 200 series
- Recommended for dissimilar welds of pure Ni grades to mild steels or CuNi alloys
- Excellent corrosion resistance in alkaline media

### Standard designations

DIN EN ISO 18274	AWS A5.14	DIN Mat.-No.
S Ni 2061 (NiTi3)	ERNi-1	2.4155

### Typical chemical composition of filler metal

	C	Ti	Ni	Si	Mn	Al	Fe
Mass %	0.02	3.3	Bal.	0.3	0.35	0.2	0.1

### All weld metal properties (min. values at rt)

Heat treatment	Yield strength	Tensile strength	Elongation	Impact toughness	
	Rp0.2	R <sub>m</sub>	A <sub>5</sub>	ISO-V	
as welded	44 ksi	65 ksi	30%	150 J	

### Welding instructions

Polarity	Shielding gas acc. to AWS A5.32
DC / +	SG-A, SG-AHe, SG-A-G (He 30% - H 2% - C ~0.1)
DC / -	SG-A, SG-AHe, SG-AH (max. 5% H <sub>2</sub> DC / -)

Low heat input and interpass temperature < 248°F. Stringer bead technique recommended.

#### Base materials

2.4066 – Alloy 200 – Ni 99,2

2.4068 – Alloy 201 – Ni 99,6

CMn steels acc. to DIN EN ISO 15608 Gr. 1 - 2

### Packaging (tolerances acc. to AWS A5.02)

Approvals on request

Diameter (in)		lbs/PU
1/16 - 1/8	X 36 in	11 / 22
0.035 – 0.045	BS 300 spool	33
0.06 – 1/8	K 415 / K 435 spool	55