

❖ Product Description

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| I. A low carbon 96Ni/3Ti Nickel wire | V. Low iron level ensures max corrosion resistance |
| II. Almost pure Ni deposit | VI. Radiographic weld quality |
| III. Excellent ductility and strong weld metal | |
| IV. Resistant to cracking and oxidation | |

❖ Range of Application

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| I. For welding of wrought and cast form of pure Ni | IV. Application in pumps and valves, cryogenics, chemical plants, caustic handling equipment, food processing equipment |
| II. For welding Nickel 200 and 201 | |
| III. Suitable for ASTM B160/161/162/163 | V. Overlay on carbon and low alloy steel |

❖ Classification

- AWS/SFA 5.14 ERNi-1

❖ % Chemical Composition

Type of Wire		C	Mn	Fe	S	Si	Cu	P	Ni	Cu	Al	Ti	Other Elements
ERNi-1	Min	-	-	-	-	-	-	-	93.0	-	-	2.0	-
	Max	0.15	1.0	1.0	0.015	0.75	0.25	0.03	-	0.25	1.5	3.5	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
As Welded	380	-	30	-

❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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