

Standards
**Chemical Composition of
Welding Wire % (Typical)**

AWS A5.14 : ER - Ni 1

Ni	C	Si	Mn	Ti
Rest	0.02	0.4	0.4	3.0

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))
min. 300	min. 500	min. 250 J	min. 30

Typical Base Material Grades

- 2.4061, 2.4116, 2.4170 as well as copper and its combinations with steel castings

Features and Applications

- Use in various applications of joint-welding of the materials Nickel 200/201 or stainless steels. Suitability for use in welding of carbon steels or of high-alloyed nickel or nickel-copper alloys
- Required use of Ar (I1) as shielding gas in TIG welding

Welding Positions

Current Type

TIG D.C.(-)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6031100304	1.20	0,047"	15
6031100110	2,4 x 1000	3/32 x 39"	5

Approvals: SEPRO