

NiTi 3 Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Solid Nickel based filler metal for Tig welding.

APPLICATIONS NiTi 3 is developed for welding and cladding Nickel 200 and Nickel 201. This alloy is also suited for surfacing of steel. Dissimilar welding applications of filler metal NiTi 3 include joining Nickel 200 and 201 to stainless steels, copper-nickel alloys, and Monel alloys. It is also used for joining Monel alloys and copper-nickel alloys to carbon steels, and for joining copper-nickel alloys to Inconel en Incoloy alloys.

PROPERTIES The reaction of titanium with carbon maintains a low level of free carbon and enables the filler metal to be used with Nickel 201. The weld metal has good corrosion resistance, particularly in alkali's.

CLASSIFICATION

AWS	5.14: ER Ni-1
EN ISO	18274: S Ni 2061
DIN: W.Nr.	2.4155
DIN	1736:

SUITABLE FOR NiTi 3 is developed for welding and cladding Nickel 200 and Nickel 201. This alloy is also suited for surfacing of steel. Dissimilar welding applications of filler metal NiTi 3 include joining Nickel alloy 200 and 201 to stainless steels, copper-nickel alloys, and Monel alloys. It is also used for joining Monel alloys and copper-nickel alloys to carbon steels, and for joining copper-nickel alloys to Inconel en Incoloy alloys. Type of alloys : Nickel 200 - Nickel 201, UNS Nr (unified numbering system) : N 02200 - N 02201. DIN 17 742: Ni 99.6 ; Ni 99.2 ; LC-Ni99.6 ; LC-Ni99 Mat n° : 2.4060 - 2.4061 - 2.4066- 2.4068

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	S	P	Ti	Fe	Al	Cu	Ni+Co
< 0.15	< 1.0	< 0.75	< 0.015	< 0.030	2.0-3.5	< 1.0	< 1.5	< 0.25	> 93.0

MECHANICAL PROPERTIES

Heat Treatment	Tensile strength		Elongation (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
	(PSI)	(MPA)		20°C	40°C	60°C	
AW	60.000	414	20	120			

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing (kg)	
	Current (A) DC-		single	master
1.6 x 1000	50-80		5	25
2.0 x 1000	70-110		5	25
2.4 x 1000	110-180		5	25
3.2 x 1000	150-250		5	25

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1