



# AUTOMIG Ni-1

GMAW NICKEL ALLOYS

AWS A/SFA 5.14 ERNi-1

### CLASSIFICATION:

EN ISO 18274  
SNi 2061 (NiTi3)

### KEY FEATURES:

- A low carbon 96Ni/3Ti Nickel wire
- Almost pure Ni deposit
- Extremely strong and ductile weld metal
- Resistant to cracking and oxidation
- Low iron level ensure maximum corrosion resistance
- Radiographic weld quality

### TYPICAL APPLICATIONS:

- Welding of wrought and cast form of commercially pure Ni (99.5%)
- Welding of Nickel 200 and 201
- Suitable for ASTM B160/161/162/163
- For dissimilar welding between Nickel 200/201 and various iron-base and nickel-base alloys
- Applications in Pumps and valves, Cryogenics, Chemical plants, Caustic handling equipments, Food processing equipments
- Overlay on carbon and low alloy steel
- Used for handling corrosive alkalis and halides

### CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Fe	Si	Cu	Al	Ti	Ni
0.15 max	1.0 max	1.0 max	0.75 max	0.25 max	1.5 max	2.0-3.5	93.0 min

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	380	30

### PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		All Positions
1.2	12.5	 <b>DCEP</b> <b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box	
1.6	12.5		

Shielding Gas	Gas Flow Rate, LPM
75Ar/25He	15-22