CEWELD®

NiTi3

CATEGORY	GMAW-GTAW Solid wires
TYPE	Solid Nickel based filler metal for Mag 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 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 strenght (PSI)	Tensile strenght (MPA)	Elongation (%)	Impact Energy (J) ISO-V 20°C	Impact Energy (J) ISO-V 40°C	Impact Energy (J) ISO-V 60°C	Hardness HRc / HV
AW	60.000	414	20	120			

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spooling type	kg / spool	kg / pallet
0.8			KD-300	15	
1.0			KD-300	15	
1.2			KD-300	15	

REDRYING TEMPERATURE	not required
GAS ACC. EN ISO 14175:	I1, Argon+He (70/30)