



Nickel 61 (ERNi-1)

CLASSIFICATIONS: AWS A5.14/ASME SFA 5.14 Class ERNi-1 UNS N02061

DESCRIPTION: Nickel 61 is used for TIG, MIG and SAW welding of nickel 200 and 201. It is also used for overlaying on steel. Dissimilar applications include joining nickel 200 and 201 to stainless steels, carbon steels, nickel and copper-nickel alloys.

TYPICAL CHEMISTRY:

C	Cr	Ni+ Co	Mo	Mn	Si	P	S	Fe	Cu	Al	Ti	Others
.15 max		93.0 min		1.0 max	.75 max	.03 max	.015 max	1.0 max	.25 max	1.5 max	2.0- 3.5	.50 max

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	66,500 psi (460 MPa)
Yield Strength	38,000 psi (260 MPa)
Elongation	28%

TYPICAL WELDING PARAMETERS:

	Diameter	Voltage	Amperage	Shielding Gas
MIG	.035" (.9mm)	26-29	150/190	75% Ar/25% He
	.045" (1.14mm)	28-32	180/220	
	.062" (1.6mm)	29-33	200/250	
TIG	.035" (.9mm)	12-15	60-90	100% Ar
	.045" (1.14mm)	13-16	80-110	
	1/16" (1.6mm)	14-18	90-130	
	3/32" (2.4mm)	15-20	120-175	
	1/8" (3.2mm)	15-20	150-220	
SAW	3/32" (2.4mm)	28-30	275-350	Suitable Flux
	1/8" (3.2mm)	29-32	350-450	
	5/32" (4.0mm)	30-33	400-550	

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

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