



FILLER METAL 141 (ENi-1)

DESCRIPTION: Filler Metal 141 is used for shielded-metal-arc welding of Nickel 200 and Nickel 201, welding the clad side of nickel-clad steel, and surfacing of steel. The reaction of titanium with carbon in the weld metal holds free carbon to a low level so that the electrode can be used with low-carbon nickel (Nickel 201). The weld metal has good corrosion resistance, especially in alkalis. The electrode is also used for dissimilar welding, including joints between Nickel 200 or 201 and various iron-base and nickel-base alloys. Nickel Welding Electrode 141 can be operated in all welding positions. The electrodes provide excellent operability for groove and fillet welding in the downhand position and the smaller diameter electrodes are also suitable for all position welding. Power supply: direct current, electrode positive.

SPECIFICATIONS: AWS A5.11 ENi-1 (UNS W82141)
 ASME 11, Port C, SFA-5.11, ENi-1 (UNS W82141)
 ASME IX, F-No.41
 *DIN 1736 EL-Nix3 (2.dl56)
 *(EN) ISO 14172 - Mi2061 (NiTi3)

*Supply to these specifications available upon request. For manufacture to ASME III (NCA3800, N~2400)MIL and other specifications please refer your inquiry to the Technical Department prior to order placement.

TYPICAL CHEMISTRY:

Ni+Co92.0 min.	Cu	0.25 max.
C	0.10 max.	A.....	1.0 max.
Mn	0.75 max.	Ti	1.0-4.0
Fe	0.75 max.	P	0.03 max.
S.....	0.02 max.	Other.....	0.50 max.
Si.....	1.25 max.		

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength, psi	60,000
MPa	414
Elongation, (4d) %	20

AVAILABLE PRODUCT FORMS:

Diameter	mm	2.4	3.2	4.0	4.8
	in	3/32	1/8	5/32	3/16
Length	mm	305	356	356	356
	in	12	14	14	14
Current (DC+)	A	65-85	90-125	125-170	170-225

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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