

NIFIL Ni1 is an S Ni 2061 / ER Ni-1 type solid MIG welding wire, supplied with precision layer wound, depositing Ni-3Ti1Mn weld metal. Suitable for use with inert shielding gases.

NIFIL Ni1 is suitable for welding pure nickel alloy to itself and dissimilar metal welding applications. Applications include process equipment handling alkalis and halides including chlorination and evaporation of caustic soda.

NIFIL Ni1 contains sufficient Titanium to control weld metal porosity.

Solid wire for welding or hardfacing alloys with the same chemical composition. Good appearance and excellent resistance to chemical agents.

### Classification

EN ISO	18274: S Ni 2061 (NiTi3)
AWS	A5.14: ER Ni-1

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni	Fe	Ti
0.1	1	0.7	≤ 0.020	≤ 0.015	Rest	0.5	3

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				+20 °C
As Welded	≥ 280	≥ 380	≥ 38	≥ 200

Gas test: ArHeH+C 30/2/0.12

**Shielding Gas** - EN ISO 14175 : I1, I3

### Materials

2.4155

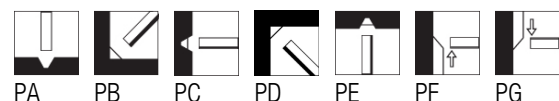
Buffer layers for welding Ni- or Cu-alloys to steels

### Storage

Keep dry and avoid condensation.

### Current condition and welding position

DC+



### Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15
1.0	W000283159