

OK Autrod Ni-1

A continuous solid nickel based electrode alloyed with about 3 % Ti for welding of high purity nickel (min 99.6 %Ni), ordinary wrought nickel and nickel with reduced C content. The weld metal can be used in a wide range of applications where the construction is working with corrosive media.

Specifications

Classifications	SFA/AWS A5.14 : ERNi-1 EN ISO 18274 : S Ni 2061 (NiTi3)
Approvals	VdTÜV : 12658 (MV) VdTÜV : 12664 (FP)

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Nickel (Ni + 2.5 % Ti)
Shielding Gas	I1, I2, I3 (EN 439)

Typical Wire Composition %

C	Mn	Si	Ni	Al	Cu	Ti	Fe
0.01	0.4	0.5	96	0.06	0.01	3.1	0.04

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Al	Cu	Ti	Fe
0.02	0.4	0.3	0.01	0.01	93	0.1	0.1	3	0.2

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm (0.030 in.)	70-190 A	20-27 V	5.0-18.0 m/min (197-709 in./min)	1.3-4.8 kg/h (2.9-10. lbs/h)
1.0 mm (0.040 in.)	100-200 A	21-27 V	6.0-13.0 m/min (236-512 in./min)	2.5-5.5 kg/h (5.5-12. lbs/h)