011121MBA

Coated SMAW Electrode

WA GAMMA 201-E



CLASSIFICATION

ASME II C SFA 5.11 / AWS A 5.11: EN ISO 14172: UNS number: Material number : ASME IX Qualification ENi-1 E Ni 2061 (NiTi3) W82141 2.4156 QW432 F-N° 41

DESCRIPTION

- Basic coated low carbon pure nickel SMAW electrode
- Contains 1-2% titanium for deoxidation and refinement

APPLICATIONS

- Welding pure nickel to itself
- · Surfacing nickel-copper, copper-nickel and copper base cladded steels
- Joining nickel-copper and copper-nickel alloys to carbon steels, to stainless steels or to nickel base alloys.

Alloy	UNS	EN Designation	Material Number
200	N02200	Ni99.2	2.4066
201	N02201	LC-Ni99	2.4068
205	N02205	LC-99.6	2.4061
		Ni99.6	2.4060

TYPICAL ALL-WELD METAL ANALYSIS [%]

С	Mn	Si	Ti	AI	Fe	Ni
0.01	0.3	0.7	1.5	0.3	0.3	Bal.

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A₅ [%]	CVN [J]		
420	280	28	-196°C: 32		
TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES					
Rm [MPa]	Rp0.2%[MPa]	A₅ [%]	CVN [J]		
480	320	30	-196°C: 170		
OPERATING CONDITION	S				
Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350		
Current [A]	70-90	90-120	120-160		
= +					

Re-drying: if necessary 1h at 350°C.

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE ASME IX: 1G, 2G, 2F, 3G, 4G

PACKAGING

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350		
Weight/box [kg]	4.0	5.0	5.0		

Other packaging and other sizes: please consult us