

Technical data sheet <small>011121MBA</small>	Nickel base filler metal – Solid wire WA TNI/MNI 201	
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CLASSIFICATION

ASME IIC SFA 5.14 / AWS A 5.14:	ERNi1
EN ISO 18274:	S Ni 2061 (NiTi3)
Equivalent material number:	2.4155
ASME IX Qualification	QW432 F-N° 42

DESCRIPTION

- GTAW rod / GMAW nickel base solid wire
- Low carbon pure nickel composition with titanium addition for deoxidation and grain refinement

APPLICATIONS

WA TNI/MNI 201 are designed for joining pure nickel to itself and for welding buffer layers on the copper side when joining copper alloys to steel or stainless steel.

Examples:

UNS	EN Designation	Material Number
N02200	Ni 99.2	2.4066
N02201	LC-Ni99	2.4068
N02205	LC-Ni99.6	2.4061

TYPICAL WIRE ANALYSIS (weight %)

C	Mn	Si	Ti	Fe	S	P	Ni
0.015	0.4	0.2	3.0	2.2	0.005	0.005	Bal

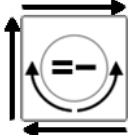
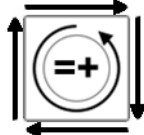
MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES (GMAW)

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
410	200	25	+20°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES (GMAW)

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
480	300	30	+20°C: 100

SHIELDING GAS – OPERATING CONDITIONS – WELDING POSITIONS

GTAW		GMAW	
Shielding gas according to EN ISO 14175	Welding positions Current type	Shielding gas according to EN ISO 14175	Welding positions Current type
I1 (100 % argon)		M12 mixed gas (Ar + 10-30% He +0.5% CO ₂) I1 (100 % argon)	

PACKAGING

Spools	Ø mm	0.8	1.0	1.2	1.6
Rods	Ø x1000 mm	1.6	2.0	2.4	3.2

Other diameters are available on request

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.