

# GETIG 801



IDENTIFICATION : ER Ni-1

CLASSIFICATION : AWS/SFA 5.14: ERNi - 1, BS 2901, pt5 : Grade NA 32, DIN 1736 : SG-NiTi4

Solid tig filler rod which deposits a low carbon pure-nickel deposit with about 3% titanium for refinement and for suppressing porosity. The deposited weld metal is of x-ray quality.

## APPLICATIONS :

For welding ASTM UNS N02200 , N02201 , BS type NA11, NA12 , Nickel 200, Nickel 201, Salt production, chlorination and evaporation of caustic soda, Handling corrosive alkalies and halides, chemical apparatus, etc

## SHIELDING GAS :

Pure Argon : 99.99% -> 8-16l/min + back purging

## CHEMICAL COMPOSITION OF THE WIRE (%):

C	Fe	Mn	Si	S	Ti	Cu	Al	Ni	P
0.10 max	1.0 max	1.0 max	0.70 max	0.015 max	2.0-3.5	0.25 max	1.50 max	93.0 min	0.025 max

## ALL WELD MECHANICAL PROPERTIES (RANGE) :

Ult. Tensile Strength N/mm <sup>2</sup> (Mpa)	Yield Stress N/mm <sup>2</sup> (Mpa)	Elongation%(L=4D)
400-500	250-350	30-40

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	PACKING PER PKT (KG.)
1.60	1000	5.0
2.00	1000	5.0
2.4/2.5	1000	5.0
3.15/3.20	1000	5.0