

NOUVE T-Ni-1

ASME SFA-5.14/SFA-5.14M ERNi-1

UNS No: N02061

APPLICATIONS:

- NOUVE T-Ni-1 is used for GTAW welding of Nickel 200 and 201, joining these alloys to stainless and carbon steels, and other nickel and copper-nickel base metals. Also used for overlaying steel.

CHEMICAL COMPOSITION OF DEPOSITED METAL (wt%) :

ELEMENTS	AWS SPEC	TYPICAL
Carbon (C)	0.15 Max	0.06
Manganese (Mn)	1.0 Max	0.30
Iron (Fe)	1.0 Max	0.10
Phosphorus (P)	0.03 Max	0.008
Sulphur (S)	0.015 Max	0.003
Silicon (Si)	0.75 Max	0.40
Copper (Cu)	0.25 Max	0.02
Nickel (Ni)	93.0 Min	Balance
Titanium (Ti)	2.0 – 3.5	3.0
Al	1.50 Max	0.50

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MECHANICAL PROPERTIES OF DEPOSITED METAL:

MECHANICAL TESTS	AWS SPEC	TYPICAL
Tensile Strength	380 MPa Minimum	450 MPa

RECOMMENDED WELDING TECHNIQUES:

Current/Polarity : DCEN
Shielding Gas : 100% Ar

SIZE (mm)	AMPERAGE (A)	VOLTAGE (V)	GAS FLOW RATE (lpm)
1.60 x 1000	80-110	13-16	10-15
2.00 x 1000	90-130	14-18	10-15
2.40 x 1000	120-175	15-20	10-15
3.20 x 1000	150-200	15-20	10-15

PACKING:

SIZE (mm)	PACKING MODE	WEIGHT (kgs.)
1.60 x 1000	PLASTIC TUBULAR BOX	5.0
2.00 x 1000	PLASTIC TUBULAR BOX	5.0
2.40 x 1000	PLASTIC TUBULAR BOX	5.0
3.20 x 1000	PLASTIC TUBULAR BOX	5.0