

NIROD Ni1 is an S Ni 2061 / ER Ni-1 type solid TIG welding rod depositing Ni-3Ti1Mn weld metal. Suitable for use with inert shielding gases.

NIROD Ni1 is used for welding pure nickel alloys and for dissimilar welding applications. Applications include process equipment handling alkalis and halides including chlorination and evaporation of caustic soda.

NIROD Ni1 contains sufficient titanium to control the weld metal porosity.

### Classification

EN ISO	18274: S Ni 2061 (NiTi3)
AWS	A5.14: ER Ni-1

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni	Fe	Ti
0.1	1	0.7	≤ 0.020	≤ 0.015	Rest	0.5	3

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				+20 °C
As Welded	≥ 280	≥ 380	≥ 38	≥ 200

Gas test: 100% Ar

**Shielding Gas** - EN ISO 14175 : I1

### Materials

2.4155

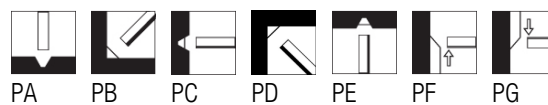
Buffer layers for welding Ni- or Cu-alloys to steels

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC-



### Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
2.0	TUB	5	●
2.4	TUB	5	●