

SUPRANEL Ni1 is a basic-coated MMA electrode for welding pure nickel components and for joining these materials to unalloyed or low-alloyed steels, dissimilar joints. Suitable for buffer layers on corrosion-resistant, unalloyed or low alloy steels, before joining to nickel or copper alloys.

Classification

EN ISO 14172: E Ni 2061

AWS A5.11: E Ni-1

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni	Fe	Ti
0.01	0.3	0.8	0.005	0.005	Rem	0.2	1.5

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-196 °C
As Welded	≥ 200	≥ 410	≥ 35	≥ 100

Materials

2.4066; 2.4068; 2.4061; 2.4060

UNS N02200; UNS N02201; UNS N02205

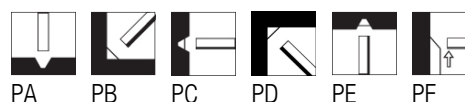
Storage

Keep dry and avoid condensation.

Re-dry at 300-350 °C for 2 hours, 5 times max

Current condition and welding position

DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	VPMD	
				PC	Code
2.5	300	50-70	18.0	90	●
3.2	350	65-100	33.5	60	●
4.0	350	85-120	50.9	40	●