

MIG-MAG Wires Nickel and Copper alloys

Nifil Ni1 is a solid wire suitable for welding alloys with similar chemical analysis and for weld overlay. Good appearance and excellent resistance to chemical corrosion.

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

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.10	1	0.70	≤ 0.030	≤ 0.015	-	98	-	-	0.90	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	≥ 280	≥ 380	≥ 38	-	-

Gas test: Acc. To EN 439: M13(Cargal1)

Shielding Gas: Acc. To EN 439: M13(Cargal1) or I3(Arcal37)

Materials

Buffer layers for welding Ni or Cu alloys to steels

Storage

Keep dry and avoid condensation.

Current condition and welding position

DC+



Packaging data: K300 Kg. 16

Diameters	1,0	1,2				
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