

Nirod Ni1 is a TIG rod suitable for welding nichel alloys with similar chemical analysis and for weld overlay. The weld deposit has a good appearance and excellent resistance to chemical corrosion.

Classification	
AWS	A 5.14: 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	-	≥ 93	-	-	0.90	-	-

### All-weld metal Mechanical Properties

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

Gas test: Acc. To EN 439: I1(Arcal1)

**Shielding Gas:** Acc. To EN 439: I1(Arcal1)

### 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-					
					
PA	PB	PC	PF	PE	PF2

**Packaging data:** Tube 5 kg

Diameters (L: 1000 mm)	2,0	2,4				
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Further forms of delivery on request.