



ER Ni-1 (ALLOY 200)

Nickel Alloy WIRE/GTAW



Standards

EN/ISO-Standard - 18274

EN/ISO-Classification - S Ni 2061 - NiTi3

AWS-Standard - A5.14

AWS-Classification - ER Ni-1

Features and Applications

- ER-Ni1 is used for the welding and cladding of Nickel 200 and Nickel 201 alloys.
- Perfect for joining Monel alloys and copper-nickel alloys to carbon steels.
- Ni1 contains enough titanium to control the weld-metal porosity on welding processes.
- Typically used in the chemical processing industries, synthetic fibre production & food processing equipment etc.
- **Test Certificates can be found online @wilkinsonstar247.com**



Typical Base Materials

Nickel 200 and 201*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF, PG

Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

Polarity

DC (-)

Chemical Composition % (Range)

C %	Mn %	Fe %	P %	S %	Si %	Cu %	Ni %	Co %	Ti %	Al %
max	max	max	max	max	max	max	93.00	max	2.00	max
0.05	0.80	0.70	0.030	0.010	0.75	0.20	min	1.00	3.50	1.00

Packaging Data

Part No.	Diameter Ø (mm)	Package Length (mm)	Package Weight (Kg)	Package Type
6031100304	1.60	1000	5	Cardboard Tube
6031100110	2.40	1000	5	Cardboard Tube

Mechanical Properties

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)
≥410	≥200	≥30	≥100

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.