



Product Data Sheet

OK Tigrod Ni-1

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GENERAL

A bare nickel based rod alloyed with about 3 % Ti for welding of high purity nickel (min 99.6 %Ni), ordinary wrought nickel and nickel with reduced C content. The weld metal can be used in a wide range of applications were the construction is working with corrosive media.

Shielding Gas: I1, I2, I3 (EN 439)

Alloy Type: Nickel (Ni + 2.5 % Ti)

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.14 ERNi-1
EN ISO 18274 S Ni 2061 (NiTi3)

CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.02		0.05
Si	0.3		0.7
Mn	0.4		0.8
P	0.01		0.03
S	0.01		0.01
Ni	93	93.0	
Cu	0.1		0.2
Al	0.1		1.0
Ti	3	2.0	3.5
Fe	0.2		0.7
Others tot			0.50

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	As welded	Min
Rp0.2 (MPa)	200	
Rm (MPa)	410	
A5 (%)	25	
at 20°C (J)	130	