

NICALLOY 1

CLASSIFICATIONS

AWSA/SFA 5.11 ENi-1

IDENTIFICATION: Name Printed

CHARACTERISTICS

A basic almost pure Nickel electrode giving a smooth arc, medium penetration and can be used in all welding positions. The weld metal is resistant to cracking, corrosion and oxidation. The slag is a little difficult to remove in a groove, which is a typical characteristic of this type of electrode. The weld are of radiographic quality. A feature of this electrode is low iron content in the weld deposit, which ensure maximum corrosion resistance. In overly applications on Carbon Steel /Low Alloy Steels a minimum of three layers must be deposited. The Weld metal is strong and extremely ductile.

TYPICAL APPLICATIONS

Welding of wrought and cast from of commercially, pure Nickel (99.5%): Overly of pure Nickle on CS/LAS; welding of ASTM B160/161/162/163 having UNS no. N02200 and N02201; welding of Nickle200 and Nickle 201.

Industry Sectors: Refineries Cryogenics, Power, Foundries, Heat Exchanger/Pressure Vessel/columns manufacturing units, Pump and Valves manufacturing units chemical shipping drums, Chemical plants, Food processing equipments, Caustic haridling equipments, etc.

CURRENT CONDITIONS: DC (+)

4.0	3.2	2.5
100-140	90-110	50-75

WELDING POSITIONS

F, H, V-up & OH

SPECIAL INSTRUCTIONS FOR WELDING

Redry the electrode at 300°C for 1 Hrs.

WELD METAL ANALYSIS (%)

C - 0.10 Max.	S - 0.02 Max.	Cu - 0.25 Max.	Ni - 92.0 Min.
Mn - 0.75 Max.	Si - 1.25 Max.	Al - 1.0 Max.	
Fe - 0.75 Max.	P - 0.03 Max.	Ti - 1.0 - 4.0	

PACKING DATA

Dia., mm	4.0	3.2	2.5
Length, mm	300	300	300
Wt. per carton, kg	1	1	1
Cartons / box	10	10	10
Net wt per box, kg	10	10	10

MECHANICAL PROPERTIES OF THE WELD METAL

Condition	UTS	% Elong. (L=4xd)
As-welded	410 MPa	20



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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