

Characteristics:

1. Pure nickel-type gas-shielded wire with a nominal composition of 96%Ni-3%Ti.
2. Because of the addition of a sufficient amount of Ti elements, can effectively reduce the welding process to produce porosity.
3. Stable arc, beautiful shaping, good iron fluidity, with excellent welding process performance.

Application:

Suitable for industrial pure nickel forgings and castings welding, such as 200, 201 alloy and nickel-plated steel, ASTM B160, B161, B162 and B163 and UNS No. N02200 and N02201, can also be used for nickel-based alloys and stainless steel dissimilar materials welding and surface surfacing.

Power polarity:DC-

Chemical composition.

Item	C	Mn	Si	Cr	Ni	Mo	Fe	Ti	P	S
AWS Standard	0.15	1.0	0.75	-	≥93	-	1.0	2.0~3.5	0.03	0.015
Example value	0.005	0.48	0.26	0.46	94.69	0.001	0.07	2.95	0.001	0.001



Mechanical properties.

Mechanical properties	Yield strength MPa	Tensile strength MPa	Elongation %	Impact value J/°C
Example value	-	550	36	276/-196

Welding Requirements.

1. Before welding, clean the base metal, welding wire, adjust the equipment.
2. Shielding gas: pure Ar.
3. Inter-pass temperature: <100°C .