Nickel Filler Metal 61

Nickel Filler Metal 61 is used for gas-tungsten-arc, gas-metal-arc, and submerged-arc welding of Nickel 200 and 201. It is also used for surfacing of steel. INCOFLUX NT100 Submerged Arc Flux is used with the submerged-arc process. The reaction of titanium with carbon maintains a low level of free carbon and enables the filler metal to be used with Nickel 201. The weld metal has good corrosion resistance, particularly in alkalies.

Dissimilar-welding applications for Nickel Filler Metal 61 include joining Nickel 200 and 201 to stainless steels, carbon steels, INCONEL alloys, INCOLOY alloys, copper-nickel alloys, and MONEL alloys. It is also used for joining MONEL alloys and copper-nickel alloys to carbon steels, and for joining copper-nickel alloys to INCONEL and INCOLOY alloys.

Specifications
AWS A5.14 ERNi-1 (UNS N02061)
ASME II, Part C, SFA-5.14, ERNi-1 (UNS N02061)
ASME IX, F-No.41
*BS 2901 Part 5 (NA32)
*DIN 1736 SG-NiTi4 (2.4155)
*(EN) ISO 18274 – SNi2061 (NiTi3)
*Supply to these specifications available upon request
For manufacture to ASME III (NCA3800, NB2400), MIL, Rolls Royce, AMS and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals
VdTUV 1284: 2108.01
Other approvals may be applicable. Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition

Ni+Co .... 93.0 min.	Si .... 0.75 max.
C .... 0.15 max.	Al .... 1.5 max.
Mn .... 1.0 max.	Ti 2.0-3.5
Fe .... 1.0 max.	P .... 0.030 max.
S .... 0.015 max.	Others .... 0.50 max.
Cu .... 0.25 max.	

Minimum Mechanical Properties

Tensile Strength, psi	60,000
MPa	414
Elongation, (4d) %	20

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

Available Product Forms

mm	0.8	0.9	1.0	1.14	1.2	1.6	2.4	3.2
in	0.030	0.035	0.040	0.045	0.047	0.062	0.093	0.125

Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)

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