

MIDALLOY ERNi-1 (FM61) BARE WIRE

CLASSIFICATION

- AWS 5.14 Class ERNi-1 / ASME SFA 5.14 Class ERNi-1

DESCRIPTION

- MIDALLOY ERNi-1 nickel alloy bare wire is used for GMAW, GTAW, and SAW welding.

APPLICATIONS

- MIDALLOY ERNi-1 nickel alloy bare wire is used for joining nickel 200 and nickel 201. This includes ASTM grades such as B160 – B163, B725 and B730.
- This alloy is useful in a variety of dissimilar applications between nickel alloys to stainless or ferritic steels.
- This versatile alloy is also used for overlaying carbon steel and in repairing cast iron castings.

TYPICAL CHEMISTRY

C	Mn	Si	Fe	S	P	Cu	Al	Ti	Ni
.03	.50	.54	.30	.003	.006	.01	.03	2.46	96.1

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	65,000 PSI
YIELD STRENGTH	37,000 PSI
ELONGATION	27%

RECOMMENDED WELDING PARAMETERS

(See attached)

STANDARD PACKAGING

- TIG 10 lb. tube / 60 lb. carton
- MIG 30 lb. spool
- SUB-ARC 60 lb. coil

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