

MIDALLOY NI-MAX 141 COATED ELECTRODE

CLASSIFICATION

- AWS/SFA 5.11 Class ENi-1/ASME SFA 5.11 Class ENi-1, ASME F No 41, UNS W82141

DESCRIPTION

- Midalloy Ni-Max 141 coated electrode is an all-position, high nickel coated electrode used for joining alloy Nickel 200 and 201 (UNS number N02200 and N02201) to themselves as well as other nickel alloys.
- Ni-Max 141 can also be used for dissimilar welds between most nickel-based alloys such as UNS number N04400, stainless steel, and low alloy or carbon steels, without need to preheat. (Stress-relief may follow if required.)

APPLICATION

- Ni-Max 141 coated electrodes deposits have excellent caustic corrosion resistance and are used in many chemical-processing industries.
- Midalloy Ni-Max 141 is used as a buffer layer when cladding carbon steel with copper nickel and nickel copper alloys.

TYPICAL CHEMISTRY

C	Mn	Fe	P	S	Si	Cu	Ni	Ti	Al	Others
0.02	0.43	0.40	0.01	0.01	0.48	0.01	94.5	1.2	0.03	<0.5

TYPICAL MECHANICAL PROPERTIES

Tensile Strength	63,000 PSI
Yield Strength	30,000 PSI
Elongation	21%
Hardness (on ferrous metal)	86 RB (1 to 3 layers)

RECOMMENDED WELDING PARAMETERS

Diameter	3/32"	1/8"	5/32"	3/16"
Process	SMAW	SMAW	SMAW	SMAW
Voltage	24-28	26-30	28-32	28-32
Amperage Flat	70-85	85-110	110-140	120-160
Amperage Vertical/Overhead	65-75*	80-90*	100-120	110-130

* These sizes are better suited for the vertical and overhead positions

STANDARD PACKAGING

- 3/32" – 8 lb. Can, 48 lb. Carton
- 1/8", 5/32", 3/16" – 10 lb. Can, 60 lb. Carton

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