



# CEWELD NiTi3 Tig

**TYPE** Solid Nickel based filler metal for TIG welding.

**APPLICATIONS** CEWELD® NiTi 3 is developed for welding and cladding Nickel 200 and Nickel 201. This alloy is also suited for surfacing of steel. Dissimilar welding applications of filler metal NiTi 3 include joining Nickel 200 and 201 to stainless steels, 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 en Incoloy alloys.

**PROPERTIES** 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 alkali's.

**CLASSIFICATION**

|        |                         |
|--------|-------------------------|
| AWS    | A 5.14: ERNi-1          |
| EN ISO | 18274: S Ni 2061(NiTi3) |
| F-nr   | 41                      |
| FM     | 6                       |

**SUITABLE FOR**

**Ni 2061 (NiTi3)**  
**W.Nr:** 2.4060, 2.4061, 2.4062, 2.4066, 2.4068, 2.4106, 2.4108, 2.4109, 2.4110, 2.4116, 2.4122, 2.4128, 2.4170, 2.4175  
 Ni 99.6 ; Ni 99.2 ; LC-Ni99.6 ; LC-Ni99, Ni99.4Fe, NiMn1, NiMn1C, NiMn1,5, NiMn2, NiMn3Al, NiMn5, NiAl4Ti, G-Ni95, G-Ni93C  
**ASTM** B160, B161, B162, B163  
**UNS:** N02200, N02201, N02205  
**Alloy:** 200, 201, 205, Monell

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

| C    | Si  | Mn  | P    | S     | Ni | Ti | Fe  | Cu  |
|------|-----|-----|------|-------|----|----|-----|-----|
| 0.09 | 0.5 | 0.7 | 0.01 | 0.008 | 96 | 3  | 0.2 | 0.1 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Impact Energy (J) ISO-V | Hardness |
|----------------|----------------------------|-------------------------|-----------|-------------------------|----------|
|                |                            |                         |           | RT                      |          |
| As Welded      | 200                        | 420                     | 30        | 120                     | HRc      |

**REDRYING** Not required

**GAS ACC. EN ISO 14175** 11



## CEWELD NiTi3 Tig

NIT13 TIG 1,6 X 914MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 4,54    | 8720663417749 |

NIT13 TIG 2,0 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663417756 |

NIT13 TIG 2,4 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663417763 |

NIT13 TIG 3,2 X 914MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 4,54    | 8720663417770 |