

# Nickel Base Alloy SMAW Electrodes

## GNI 141

AWS A5.11 ENi-1  
JIS Z 3224 E Ni-1

### Product Features:

- Basic type nickel base electrode for DC+ only.
- The weld metal contains Ti content holds free carbon to a low level that has good corrosion resistance, particularly in porosity.
- Stable arc blow with easy slag removal and good bead appearance.

### Applications:

- Used for welding pure nickel forging components (Nickel 200 and Nickel 201), cast iron component, compound nickel steel and dissimilar steel.

### Guide in Usage:

- 300 ~ 350°C x 1hr baking prior to use.
- Recommend short arc length and low current, electrode positive (DC+).
- Full cleaning before welding.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	P	S	Ni	Ti	Fe
0.02	0.74	0.49	0.005	0.002	96.4	1.3	0.40

Typical Mechanical Properties of Weld Metal

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation (%)
293	445	24.0

Size (mm) & recommended welding parameters (A)

Diameter / Length	2.6 / 300	3.2 / 350	4.0 / 350
Flat position	65-85	70-110	95-150

### Note:

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