

Nickel Base Alloy MIG•TIG Wire / Rod

GTN61 / GMN61

AWS A5.14 ERNi-1
ISO 18274-S Ni 2061
JIS Z 3334 YNi-1

Product Features:

- Nickel alloy bare wire is used for GTAW and GMAW.
- Weld metal contains Al and Ti content which have excellent corrosion resistance in many aggressive media and is especially aid to deoxidation and pitting resistance.

Applications:

- Used for gas-tungsten-arc welding of Nickel 200 and 201, variety of dissimilar applications between nickel alloys to stainless or ferritic steel. It is also used for overlaying carbon steel and in repairing cast iron castingswelding of similar grade of nickel base alloy.

Shielding gas:

- Ar + 0.5~2.0%O₂ (GMAW)
- 100% Ar (GTAW)

Typical chemical composition of wire / rod (wt%)

C	Si	Mn	Ni	Al	Ti
0.03	0.20	0.4	96	0.2	3.40

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
514	40

MIG wire size (mm) & recommended welding parameters (A)

Diameter	0.9/1.0	1.2	1.6
Current range	70~100	80~110	90~130

TIG rod size diameter/length

Diameter (mm)	1.6	2.0	2.4	3.2
Length (mm)	1000	1000	1000	100

Note:

Recommend pulse or spray arc (low current) for RT examination purpose.

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