SWASTIK-WELD
JINIK MARKETING

**Nickle & Nickle Alloys Welding Wires**

**Product: Swastik Weld**

**Nickle & Nickle Alloys:**

**Chemical Composition**

| Wire Grades as Per AWS 5.14 | "Swastik Weld" ER Ni1 | "Swastik Weld" ER NiCu-7 | "Swastik Weld" ER NiCr3 | "Swastik Weld" ER NiCrMo3 |
|---|---|---|---|---|
| C | 0.15max | 0.15max | 0.03-0.10 | 0.10max |
| Mn | 1.0max | 4.0max | 2.5-3.5 | 0.50max |
| Si | 0.75max | 1.25max | 0.50max | 0.50max |
| S | 0.015max | 0.015max | 0.015max | 0.015max |
| P | 0.03max | 0.02max | 0.03max | 0.02max |
| Cu | 0.25max | Remainder | 0.50max | 0.50max |
| Cr | - | - | 18.0-22.0 | 20.0-23.0 |
| Ni | 93.0min | 62.0-69.0 | 67.0min | 58.0min |
| Fe | 1.0max | 1.25max | - | 0.40max |
| Al | 1.50max | 1.25max | - | 0.40max |
| Ti | 2.0-3.5 | 1.5-3.0 | 0.75max | 0.40max |
| Nb+Ta | - | - | 2.0-3.0 | 3.15-4.15 |
| Mo | - | - | - | 8.0-10.0 |
| Others | 0.50max | 0.50max | 0.50max | 0.50max |

**Diameters (mm):**

1) In Mig spools of size: 0.80mm, 1.00mm, 1.20mm & 1.60mm
2) In Tig Form of sizes: 1.60mm, 2.40mm, 3.15mm, 4.00mm ( 1000mm length)

**Standard Packing:**

1) Mig Packing in 12.5 kgs spool
2) Tig Packing in 5 kgs Plastic Tube

**Works: Gala No. 19, Syndicate Indl. Complex, Near Golani Naka, Near Bank of Maharashtra, Wallive Road, Vasai (E), Dist. Thane - 401 208. Email: swastikweld@gmail.com, Skype: kamal.mehta14, Mobile: +91 9321434296, www.jinikmarketing.com**

SWASTIK-WELD
JINIK MARKETING

**Nickle & Nickle Alloys Welding Wires**

**Product: Swastik Weld**

# Applications

**AWS A5.14 ERNi-1**

This wire is used for TIG, MIG and SAW welding of nickel 200 or 201. This filler metal is also employed for overlaying on steel as well as repairing cast iron castings. It can also be used for dissimilar joints between nickel or nickel alloys to stainless or ferritic steels.

**AWS A5.14 ERNiCu-7**

ERNiCu-7 is used for TIG, MIG and oxy-fuel welding of 70/30, 80/20 and 90/10 copper-nickel alloys. This filler metal can be used for MIG overlay on steel after a first layer with nickel 208 (Filler Metal 61). Dissimilar-welding applications include joining copper-nickel alloys to Nickel 200 or nickel-copper alloys.

**AWS A5.14 ERNiCr-3**

ERNiCr-3 is used for TIG, MIG and SAW welding of base materials such as ASTM B163, B166, B167 and B168 alloys which have UNS Number N06600. It is one of the most used nickel alloys whose applications range from cryogenic to high temperatures. This filler metal can also be used for dissimilar welding applications between various nickel alloys and stainless or carbon steels, as well as for overlaying.

**AWS A5.14 ERNiCrMo-3**

ERNiCrMo-3 LOW IRON is used for TIG, MIG and SAW welding of nickel-chrome-molybdenum alloys. This filler metal is very versatile in its applications. It can be used for welding of dissimilar joints between nickel-chrome-molybdenum alloys and stainless or carbon or low alloy steels. It can also be used for cladding as well as for spraying applications. Techalloy 625 with low iron (less than 0.8% is preferred in various applications where dilution of iron must be controlled to the minimum.

The high alloy content of ERNiCrMo-3 enables it to withstand highly corrosive environments. The combination of nickel and chromium provides the resistance to oxidizing conditions and the combination of nickel and molybdenum provides resistance to reducing conditions. Due to its molybdenum content, this alloy offers resistance to stress corrosion cracking, pitting and crevice corrosion.

**Diameters (mm):**

1) In Mig spools of size: 0.80mm, 1.00mm, 1.20mm & 1.60mm
2) In Tig Form of sizes: 1.60mm, 2.40mm, 3.15mm, 4.00mm ( 1000mm length)

**Standard Packing:**

1) Mig Packing in 12.5 kgs spool
2) Tig Packing in 5 kgs Plastic Tube

**Works: Gala No. 19, Syndicate Indl. Complex, Near Golani Naka, Near Bank of Maharashtra, Wallive Road, Vasai (E), Dist. Thane - 401 208. Email: swastikweld@gmail.com, Skype: kamal.mehta14, Mobile: +91 9321434296, www.jinikmarketing.com**