

International standards	Material No.	2.4156
	DIN 1736	EL-NiTi 3
	AWS A5.11	ENi-1

Approvals ---

Typical applications and characteristics Basic coated electrode with a nickel deposit containing 1-2% Titan, designated for butt welding and surfacing of nickel-copper, copper-nickel and copper-nickel plated steels. Also recommended for dissimilar joining like: steel/ nickel-copper or steel/copper/copper-nickel. Excellent resistance to stress corrosion in chloride-containing environments. Main applications: construction of equipment for chemical and petrochemical industry, food stuff industry, naval constructions and installations for sea water desalination.

Base materials	2.4060 Ni99,6	2.4109 NiMn1,5	USN N02200
	2.4061 LC-Ni99,6	2.4110 NiMn2	N02201
	2.4062 Ni99,4Fe	2.4116 NiMn5	N02205
	2.4066 Ni99,2	2.4122 NiMn3Al	
	2.4068 LC-99	2.4128 NiAl4Ti	Alloy 200
	2.4106 NiMn1	2.4170 G-Ni95	201
	2.4108 NiMn1C	2.4175 G-Ni93C	205

Mechanical properties of all-weld metal	Tensile strength R_m N/mm ²	Yield strength $R_{p0,2}$ N/mm ²	Elongation A_5 %	Impact strength ISO – V J at -196 ° C
	(typical values)	470	310	>30 120

Weld metal analysis (typical, wt. %)	C	Mn	Si	Ti	Ni	Fe	Al
	< 0,02	0,4	1	2,0	Bal.	0,3	0,2

Current = +

Welding positions PA, PB, PC, PD, PE, PF

Rebaking 1 h, 300 °C + / - 10 °C (if required)

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 300	70 - 90	244	976	20,5	5,0	20,0
3,2 x 350	90 - 120	148	592	33,8	5,0	20,0
4,0 x 350	110 - 160	98	390	51,2	5,0	20,0

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.