



61 XM/XT

AWS A 5.14: ER Ni-1
ISO 18274: NiTi3 – S Ni 2061

DESCRIPTION

Pure nickel wire for welding of nickel steels, for surfacing of steel, for welding cast iron and carbon steel.

Applications: Tanks and vessels, engine blocks, heat exchangers, chemical industry etc.

WELDING POSITIONS



CURRENT

DC (+) Mig
DC (-) Tig

GAS

Mig Ar/Co2
Tig, Ar

BASE MATERIAL

Cast iron, gray cast iron, nickel alloys, steel

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_p</i> (Mpa)	<i>A5</i> (%)	<i>Hardness</i>
580	330	30	180HB

CHEMICAL COMPOSITION(%)

C	Mn	Si	Ni	Ti	Fe
0,02	0,4	0,4	Rest	3,3	<0,2

PACKAGING

Dimension MIG (mm)	0,8	1,0	1,2
Spool (kg)	15	15	15
Item code MIG	8M61082501	8M61102501	8M6116R001
Dimension TIG (mm)	1,6x1000	2,0x1000	2,4x1000
Box (kg)	5	5	5
Item code TIG	8M6116R001	8M6120R001	8M6124R001

EQUIVALENT CONSUMABLES

MMA	Meltolit 61XE
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