



# CEWELD E NiTi3

**TYPE** Nickel based basic stickelectrode for welding pure nickel

**APPLICATIONS** **CEWELD® E NiTi3** has been developed for welding and cladding nickel 200 and nickel 201. This alloy is also suitable for cladding steel. It is also used for joining Monel alloys and copper-nickel alloys to carbon steels and for joining copper-nickel alloys to Inconel or Incoloy alloys. It is mainly used where good corrosion and temperature behavior is required. **CEWELD® E NiTi3** applications pressure vessel and apparatus construction, in the chemical industry, the food industry and in the energy industry.

**PROPERTIES** Due to the reaction of titanium with carbon, the proportion of free carbon remains low, so that **CEWELD® E NiTi3** can be used for nickel 201. The weld metal has good corrosion resistance, especially in alkalis.

**CLASSIFICATION**

AWS	A 5.11: E Ni-1
EN ISO	14172: E Ni 2061
W.Nr.	2.4156
F-nr	41
FM	6

**SUITABLE FOR**

**Ni 2061 (NiTi3)**  
**W.Nr:** 2.4060, 2.4061, 2.4062, 2.4066, 2.4068, 2.4106, 2.4108, 2.4109, 2.4110, 2.4116, 2.4122, 2.4128, 2.4170, 2.4175  
 Ni 99.6 ; Ni 99.2 ; LC-Ni99.6 ; LC-Ni99, Ni99.4Fe, NiMn1, NiMn1C, NiMn1,5, NiMn2, NiMn3Al, NiMn5, NiAl4Ti, G-Ni95, G-Ni93C  
**ASTM** B160, B161, B162, B163  
**UNS:** N02200, N02201, N02205  
**Alloy:** 200, 201, 205, Monell

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	Ni	Ti	Fe	Cu
0.08	1	0.6	Rem.	3	0.5	0.1

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	330	510	28	160		HRc

**REDRYING** 300°C / 2 hr

**GAS ACC. EN ISO 14175**



# CEWELD E NiTi3

E NIT13 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419156

E NIT13 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419163

E NIT13 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,27	8720663417671