

GMAW Wire for Nickel and Nickel-Based Alloy

KMS-96

Shielding Gas: 75% Ar+25%He

Classification

AWS	A5.14/A5.14M	ERNi-1
JIS	Z3334	S Ni 2061
EN	18274	S Ni 2061
GB	T15620	S Ni 2061

Applications and Features

- (1) Good corrosion resistance, particularly in alkalis.
- (2) Ideal for welding materials of similar composition, such as nickel 200 and 201.
- (3) Suitable for welding Monel alloys and copper-nickel alloys to carbon steels and copper-nickel alloys to Inconel as well as Incoloy alloys.

Welding Position



Welding Instruction

- (1) Clean surface of base metal before welding.
- (2) For other instructions, please refer to Appendix B.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	Fe	Ti	Ni
0.018	0.34	0.24	0.14	0.34	95.5

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
514	299	44	-	-

Size and Suggested Operating Range (DC+)

Diameter (mm)	0.9	1.2	1.6
Current (A)	150~190	180~220	200~250
Voltage (V)	26~29	28~32	29~33