

# Welding Alloys: MIG-TIG Wire

JLC Classification	NiTi	NiCuTi	CuNiTi	CuNi10Fe	NiCr20Nb	Nickel 99.2	NiFe 55:45	NiFe 60:40	JLC 625
AWS Classification	ERNi-1	ERNiCu-7	ERCuNi	-	ERNiCr-3	-	-	-	ERNiCrMo-3
AWS Specification	A 5.14N	A 5.14N	A 5.7	-	A 5.14	-	-	-	A5.14
UNS Designation	02061	04060	C71581	-	N06082	-	-	-	N06625
Werkstoff Nr	2.4155	2.4377	2.0837	2.0873	2.4806	-	-	2.4560	2.4831
DIN	1736	1736	1733	1733	1736	-	-	-	1736

Other grades of NiFe also available. Please contact JLC for any other special grades of Nickel based MIG & TIG Wires.

## Nominal Chemical composition (%)

Ni	Min 93.0	Min 62.0	29.0-32.0	9.0-11.0	Min 67.0	Min 99.2	Min 54.0	Min 58.0	Min 58.0
Cu	Max 0.25	28.0-34.0	Balance	Balance	Max 0.5	Max 0.2	Max 0.2	Max 0.4	Max 0.50
Ti	2.0 – 3.5	1.5-3.0	0.2 – 0.5	0.2-0.5	Max 0.75	-	-	-	Max 0.40
Cr	-	-	-	-	18-22	-	-	-	20.0-23.0
Mn	Max 1.0	3.0-4.0	0.5-1.0	0.5-1.0	2.50-3.50	0.4	0.5-1.5	0.5 – 1.5	0.50 Max
Fe	Max 0.7	0.5-2.5	0.4-0.7	1.3 -1.8	Max 3.0	0.2	Balance	Balance	2.0 Max
Mo	-	-	-	-	-	-	-	-	8.0-10.0
Others	Max 0.5	Max 0.5	Max 0.25	Max 0.5	Nb: 2.0-3.0	Max 0.5	Max 0.5	Max 0.5	Nb: 3.15-4.15

Applications	GTAW, GMAW, MIG, MAG, PLASMA ARC	GTAW, GMAW, MIG, MAG, SMAW, SAW PLASMA ARC	GTAW, GMAW, MIG, MAG, PLASMA ARC	GTAW, GMAW, MIG, MAG, SAW, PLASMA ARC	GTAW, GMAW, MIG, MAG	GTAW, GMAW, MIG, MAG	GTAW, GMAW, MIG, MAG	GTAW, GMAW, MIG, MAG	GTAW, GMAW, SAW
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## Welding Wires (TIG)

Metric units		
Diameter	mm	0.8, 1.0, 1.2, 1.6, 2.0, 2.4, 3.2, 4.0, 5.0
Length	mm	1000 mm standard
Imperial units		
Diameter	inch	1/32, 3/64, 1/16, 5/64, 3/32, 1/8, 5/32, 3/16
Length	inch	36 inch standard

Wires are supplied in standard 5 or 10 kg plastic tubes

Ends (one or both) are stamped with AWS grade wherever applicable.

## Welding Wires (MIG)

Metric units		
Diameter	mm	0.8, 1.0, 1.2, 1.6, 2.0, 2.4, 3.2
Imperial units		
Diameter	inch	1/32, 3/64, 1/16, 5/64, 3/32, 1/8

Wires are supplied on S300 spools