

# Inweld Nickel 61

AWS A5.14 ERNi-1

## Chemical Composition of Inweld Nickel 61

Fe	C	Al	Ni	Ti	Mn	Si	P	S	Cu	Other
1.0	0.15	1.5	93.0 min	2.0- 3.5	1.0	0.75	0.03	0.015	0.25	0.50

Single values are maximum unless otherwise specified.

## Description and Applications

Inweld Nickel 61 is used for TIG, MIG, and SAW welding of nickel 200 and 201 to themselves or each other. This filler metal is also employed for overlay & cladding on steel as well as repairing cast iron castings. Inweld NA 61 can also be used for dis-similar joints between nickel or nickel alloys to stainless or ferritic steels. Inweld NA 61 has good corrosion resistance, particularly in alkalis.

## Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	66,500 psi
Yield Strength:	38,000 psi
Elongation:	28%

## Recommended Parameters

GMAW (DCRP – Electrode+) Spray Transfer 100% Ar or 75% Ar / 25% He Mixture

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
0.035"	26-29	150-190
0.045"	28-32	180-220
1/16"	29-33	200-250

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
0.035"	12-15	60-90
0.045"	13-16	80-110
1/16"	14-18	90-130
3/32"	15-20	120-175
1/8"	15-20	150-220

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