



# 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 |