

ASME II C SFA 5.14 : EQ Ni-1
W-Nr. : +/- 2.4155

DESCRIPTION

- SOUDOTAPE NiTi is a Nickel-base strip deoxidised with Ti
- It is designed for submerged-arc and electroslag strip cladding of alloy 200 (pure Ni)
- This strip is used for multilayer cladding in combination with fluxes RECORD EST 201, RECORD NiT or RECORD EST 200.

TYPICAL STRIP ANALYSIS

C	Mn	Si	Fe	Ti
0.023	0.3	0.1	0.1	3.9

TYPICAL WELD METAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Base metal 0.18 % C - steel.
- Strip dimensions 60 x 0.5 mm

Alloy	Layer	Strip Soudotape	C	Mn	Si	Fe	Ti	Thickn. (mm)
200	1	Record NiT	0.058	1.7	0.5	28.6	1.87	4.0
	2		0.034	1.7	0.7	12.1	2.07	3.8
	3		0.026	1.8	0.8	2.9	2.12	3.8
	1	Record EST 200	0.035	0.6	0.7	20.8	2.05	5.5
	2		0.023	0.4	0.7	5.2	2.41	5.3
	3		0.021	0.3	0.7	1.1	2.41	5.3

AVAILABLE STRIP SIZES

- Standard : 30 x 0.5 mm or 60 x 0.5 mm.

PACKING

- 30 x 0.5 mm : 25 kg to 30 kg
- 60 x 0.5 mm : 50 kg to 60 kg

Note : For additional information about cladding conditions and deposited weld metal properties, please refer to the corresponding flux technical data sheet, cladding data sheet or contact us.