TECHALLOY® 208

Nickel ▪ AWS ERNi-1

KEY FEATURES

- High nickel alloy with Al and Ti for sound deposits
- Q2 Lot® - Certificate showing actual deposit composition available online

WELDING POSITIONS

All

SHIELDING GAS

MIG 75% Ar / 25% He
TIG 100% Ar

CONFORMANCES

AWS A5.14M: 2011	ERNi-1
UNS	N02061

TYPICAL APPLICATIONS

- For TIG and MIG welding of nickel 200 and 201
- Can be used for overlay on steel as well as repairing cast iron castings
- Used for dissimilar joints between nickel or nickel alloys to stainless or ferritic steels

DIAMETERS / PACKAGING

Diameter in (mm)	MIG 33 lb (15 kg) Steel Spool	TIG 10 lb (4.5 kg) Tube 30 lb (13.6 kg) Master Carton
0.035 (0.9)	MG208035667	
0.045 (1.1)	MG208045667	
1/16 (1.6)	MG208062667	TG208062638
3/32 (2.4)		TG208093638
1/8 (3.2)		TG208125638

WIRE COMPOSITION[1] - *As Required per AWS A5.14M: 2011*

	%C	%Mn	%Fe	%P	%S	%Si
Requirements AWS ERNi-1	0.15 max	1.0 max	1.0 max	0.03 max	0.015 max	0.75 max
Typical Performance[2] Techalloy® 208	0.05	0.3	0.1	0.004	0.002	0.3
	%Cu	**%Ni**	**%Al**	**%Ti**	**%Other**	
Requirements AWS ERNi-1	0.25 max	93.0 min	1.5 max	2.0 - 3.5	0.50 max	
Typical Performance[2] Techalloy® 208	0.02	97.0	2.5	2.8	<0.50	

TYPICAL OPERATING PROCEDURES

Process	Diameter in (mm)	Voltage (volts)	Amperage	Gas
MIG	0.035 (0.9)	24-29	180-200	75% Argon / 25% Helium
	0.045 (1.1)	26-30	250-270	
	1/16 (1.6)	29-33	200-250	

[1]Typical all weld metal. [2]See test results disclaimer on pg. 13.
Safety Data Sheets (SDS) are available on our website at www.lincolnelectric.com