

CODIFICATION: AWS/SFA 5.14: ERNi-1

CHARACTERISTICS AND APPLICATIONS:

FW 1280 is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. Weld metal enhanced resistance to corrosion in caustic soda service and marine atmosphere. It is suitable for welding wrought and cast forms of pure nickel alloys like ASTM B160, B161, B162 and B163 having UNS number N02200 or N02201 to itself.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

| Element | C | Mn | Si | P | S | Ni | Ti |
|---------|-------|------|------|-------|-------|------|-----|
| Percent | 0.025 | 0.44 | 0.20 | 0.007 | 0.010 | 96.2 | 2.6 |

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

| UTS (MPa) | Elongation (L=4d) % |
|-----------|---------------------|
| 430 | 25.0 |

SHIELDING GAS : Argon

CURRENT CONDITIONS : DCEN

WELDING POSITION : H, F, VU, OH

PACKING:

| | |
|----------------------|--|
| STANDARD SIZE | Diameter 1.6 mm, 2.0 mm, 2.5 mm & 3.2 mm in cut lengths of 1000 mm each. |
| QUANTITY | 5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container. Identification – AWS code is punched on both the sides of wire. |

An ISO 9001: 2008 certified company

D & H Sécheron Electrodes Pvt. Ltd.

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