

Lastifil 900

Welding of pure nickel

CLASSIFICATION

AWS A5.14 : ER Ni-1 (UNS N02061)

GENERAL DESCRIPTION

Lastifil 900 is used for MIG welding of pure nickel and nickel alloys.
It is also used for dissimilar joints between nickel, steel and copper and between copper alloys and steel.
Lastifil 900 is also used for surfacing steel with nickel and to repair cast-iron castings especially where machinability is required.
It has a high corrosion resistance in alkaline environments.

TYPICAL USE

Chemical industry, food industry, plastic industry,...

Welding of Ni99,8 - Ni99,6 - Ni99,2 - G-Ni95 and dissimilar joints of nickel to steel and copper.

It is used for welding dissimilar materials, such as Nickel 200 and Nickel 201 with: stainless steel, Carbon steel, INCONEL, INCOLOY and MONEL.

It is also used to weld MONEL and Cupro-Nickel alloys with Carbon steel, and to weld cupro-nickel alloys with INCONEL and INCOLOY.

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C : 0.02	Ti : 3.50	Si : 0.30	P : 0.005	Mn : 0.40
Ni : 95	S : 0.01	Mo : 0.10	Co : 0.1	

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	≥ 380 MPa	≥ 20%	

GENERAL INFORMATION

Welding positions	All
Shielding gas	98% Argon + 2% CO ₂
Packing	15 kg spool (in a cardboard box)
Polarity	DC+
Diameter (mm)	1.2

Tips & tricks Nickel base metal to be cleaned very carefully from all traces of oil and impurities.
For root pass: use backing gas.

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.