



Manufacturers of Custom Welding Lines for Resale  
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# SELECTRODE 6004 Nickel Titanium TIG

## INTERNATIONAL CLASSIFICATIONS

AWS A5.14 ERNi-1  
DIN 1736 SG-NiTi4 (2.4155)

EN ISO 18274 SN: 2061 (NiTi3)

## FEATURES & APPLICATIONS

Ideal for welding of Nickel 200 or 201 to themselves or each other, overlaying on steel, welding cast iron. It is also an excellent choice for joining Nickel 200 and 201 to stainless steels, carbon steels, Inconel and Incoloy alloys, copper-nickel alloys and Monel alloys.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Al	Ti	Fe
.08	.10	.05	.035	.04	.20	.30	.20	.30	.02	2.8	Bal.

## TYPICAL MECHANICAL PROPERTIES

<b>Undiluted Weld Metal</b>	<b>Maximum Value Up to:</b>
Tensile Strength	52,000 PSI (359 N/mm <sup>2</sup> )
Elongation	22%

**TIG Welding:** The welding parameters for TIG welding are largely dependent upon the plate thickness and welding position. Straight polarity and argon or helium shielding gas should be used to minimize burn off of the tungsten electrode.