

## DIF – FILL 400

NICKEL FILLER WIRE FOR TIG, MIG, MAG WELDING

### Description:

Suitable for TIG, MIG welding for joining and surfacing of nickel alloys, clad steel, nickel to steel, copper to steel. Joining and surfacing of high and low alloyed steels. Suitable for root run and buffer layer.

### Applications:-

Suitable for welding applications in chemical industries, Root run for pipe welding, joining of heavy thickness, leak proof joints, copper to M.S. joining, hot dipped galvanized steel, S.S. joining. Excellent corrosion resistance and electrical conductivity. Porosity free welding joints. Free flowing alloy.

### Specification:

**DIN** : - 1736 - SG Ni Ti 4

**AWS** : - SFA 5.14 - ER Ni – 1

### Major Alloying Element Range:

% Element	C	Si	Mn	Fe	Ti	Ni
<b>Range</b>	0.15 max.	0.75 max.	1.0 max	1.0 max	2.0 – 3.5	93 min.

### Properties:-

Applicable Gas: - Argon + Co<sub>2</sub> + O<sub>2</sub>  
 Argon + Co<sub>2</sub>  
 Argon

Melting Range : 1250 °C to 1300 °C

Tensile strength : 440 - 540 N/ mm<sup>2</sup>

Elongation : 30 %

### Packing Standards:

Size ( dia mm) - TIG 1.6 mm, 2.0mm, 2.5mm, 3.15mm, 4.00mm

Length - 1000 mm

Packing - 5 kg per packet, 20 kg per case

Spool - MIG welding 0.8 mm , 1.2 mm , 1.6 mm, - 12.5 kg per spool.

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