

ST-60

2021.06



❖ Specification

AWS A5.14/ ASME SFA-5.14 ERNi-1
JIS Z 3334 S Ni2061 (NiTi3)
EN ISO 18274 S Ni 2061

❖ Applications

ST-60 is TIG welding consumable and it used for Nickel 200 (N02200, N02201) welding or dissimilar welding between nickel alloys to carbon steels or stainless steels.

❖ Characteristics on Usage

- ST-60 contains Ti to control weld-metal porosity.



❖ Note on Usage

Use 100%Ar gas

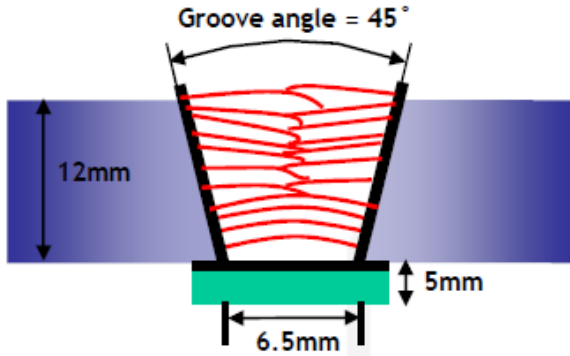
❖ Packing

Dia.	2.4mm (3/32in)	3.2mm (1/8in)
Weight	5kg (11lbs)	



Chemical Composition of Wire & Mechanical Properties of All Weld Metal (GTAW)

❖ Welding Conditions



[Joint Preparation & Layer Details]

Diameter(mm)	: 2.4mm
Shielding Gas	: 100%Ar
Flow Rate(ℓ /min.)	: 20~25
Amp./ Volt.	: 160~240
Pre-Heat(℃)	: R.T.
Interpass Temp.(℃)	: 150 ± 15
Polarity	: DC(-)

❖ Chemical Analysis of Wire(wt%)

Consumable	Chemical Composition (wt%)									
	C	Si	Mn	P	S	Ni	Ti	Al	Cu	Fe
ST-60	0.02	0.46	0.47	0.002	0.001	95.6	3.29	0.11	0.004	0.03
AWS A5.14 ERNi-1	≤0.15	≤0.75	≤1.0	≤0.03	≤0.015	≥93.0	2.0 ~3.5	≤1.5	≤0.25	≤1.0

❖ Mechanical Properties of All weld metal

Consumable	Tensile Test	
	TS MPa (ksi)	EI (%)
ST-60	561 (81)	44.8
AWS A5.14 ERNi-1	≥380 (55)	-

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