



# Techalloy 208

## Description

Techalloy 208 is used for TIG, MIG and SAW welding of nickel 200 or 201. This filler metal is also employed for overlay on steel as well as repairing cast iron castings. It can also be used for dissimilar joints between nickel or nickel alloys to stainless or ferritic steels.

## Specifications & Approvals:

AWS A5.14 ERNi-1      UNS N02061      CWB

## Typical Chemical Composition

C	Mn	Si	Fe	Cr	Mo	Ni	Nb	W	S	P	Al	Ti	Cu
.06	.3	.4	.10			95.5			.003	.008	.5	3.0	0.02

## Typical Mechanical Properties

Tensile Strength	66,500 PSI	460 MPA
Yield Strength	38,000 PSI	260 MPA
Elongation	28%	

## Welding Parameters

Process	Diameter	Voltage	Amperage	Gas
TIG	.035" (0.9mm)	12-15	60-90	100% Argon
	.045" (1.2mm)	13-16	80-110	100% Argon
	1/16" (1.6mm)	14-18	90-130	100% Argon
	3/32" (2.4mm)	15-20	120-175	100% Argon
	1/8" (3.2mm)	15-20	150-220	100% Argon
MIG	.035" (0.9mm)	26-29	150-190	75% Argon + 25% Helium
	.045" (1.2mm)	28-32	180-220	75% Argon + 25% Helium
	1/16" (1.6mm)	29-33	200-250	75% Argon + 25% Helium
SAW	3/32" (2.4mm)	28-30	275-350	Suitable Flux may be used
	1/8" (3.2mm)	29-32	350-450	Suitable Flux may be used
	5/32" (4.0mm)	30-33	400-550	Suitable Flux may be used

## Standard Packages:

MIG Wire– 33# wire basket	TIG Wire– 10# tube/30# Master Carton	SAW– 60# Coil
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