

## GEN 208 Welding Wire and Rod

GEN 208 is used for GMAW, GTAW, and SAW of Nickel 200 and 201. It can also be used in dissimilar welding applications such as joining Nickel 200 and 201 to carbon steel, stainless steel, and copper-nickel alloys. Additionally, GEN 208 is used for surfacing of steel.

### CONFORMANCES

AWS A5.14	:	ERNi-1
ASME SFA-5.14	:	ERNi-1
UNS	:	N02061

### AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Mn	%Ni	%Cu	%Fe	%Al
0.15 max. 0.04	1.0 max. 0.38	93.0 min. 95.50	0.25 max. 0.015	1.0 max. 0.18	1.50 max. 0.10
%Si	%P	%S	%Ti	Total Others	
0.75 max. 0.57	0.03 max. 0.003	0.015 max. 0.003	2.0 – 3.5 2.95	0.50 max.	

### TYPICAL WELD METAL MECHANICAL PROPERTIES

Tensile Strength	:	65,000 psi	448 MPa
Yield Strength	:	36,000 psi	248 MPa
Elongation	:	28 %	

### TYPICAL WELDING PARAMETERS\*

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	1.6 mm	14 – 18	90 – 130	100% Ar
	3/32"	2.4 mm	15 – 20	120 – 175	100% Ar
	1/8"	3.2 mm	15 – 20	150 – 220	100% Ar
MIG (GMAW)	.035"	0.9 mm	26 – 30	150 – 200	75% Ar – 25% He
	.045"	1.1 mm	28 – 32	170 – 220	75% Ar – 25% He
Sub Arc (SAW)	.093"	2.4 mm	28 – 31	275 – 350	
	.125"	3.2 mm	29 – 32	350 – 450	

\*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

<b>IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED</b> BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.
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