

# SM-60 / ST-60

## Conformances

AWS A5.14/ ASME SFA5.14 ERNi-1  
 JIS Z3334 SNi2061 (NiTi3)  
 EN ISO 18274 S Ni 2061

## Applications

- Salt Production line
- Cast irons to give soft low strength deposit
- Dissimilar welding and buffer layers

## Features

- Heavy multipass deposits or highly restrained joints may require preheat up to 150°C

## Welding Position

### Current

GMAW: DC+(Pulse)  
 GTAW: DC-

### Shielding Gas

Ar, Ar + He

### Diameter / Packaging

Diameter	MIG	TIG
mm (in)	12.5kg (27.8lbs)	5kg (11lbs)
1.0 (0.040)	✓	
1.2 (0.045)	✓	
1.4 (0.052)	✓	
1.6 (1/16)	✓	
2.0 (5/64)		✓
2.4 (3/32)		✓
3.2 (1/8)		✓

## Typical Chemical Composition of the Wire (%)

C	Si	Mn	P	S	Ni	Ti
0.02	0.40	0.4	0.005	0.001	96.0	3.0

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
	480 (70,000)	30.0	-	-

## Typical Welding Parameters

Diameter, Polarity Shielding Gas	Amp. (A)	Volt. (V)
	1.2mm (0.045 in) DC+	
Ar, Ar + He	150	29
	2.4mm (3/32 in) DC-	
Ar	110	12

SMW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX