

The nickel foil made at Special Metals, Hereford, UK, is made by a continuous electrodeposition process, producing a foil of consistent quality in greater widths and lower thicknesses than are available by conventional metal rolling, both in the hard (“as-electroformed”) and annealed conditions.

Electroformed nickel foil has very high chemical purity, excellent and consistent surface finish, and good etching characteristics. Its applications include battery mesh, heating elements, bursting discs, gaskets, lead frames and printed resistor/circuit boards. Other applications have utilized the inherent magnetic properties of nickel.

Composition and physical and mechanical properties are outlined in Tables 1, 2 and 3. For comparison of mechanical properties, the tensile strength of wrought, annealed nickel is about 450 MPa (65 ksi), and the elongation is around 40%. Hard-rolled nickel strip has a tensile strength of 620-790 MPa (90-115 ksi), and an elongation of 15-10%.

Table 1 - Typical Composition, %

Nickel	99.95 min.
Carbon	0.01 max.
Chromium	0.01 max.
Cobalt	0.01 max.
Copper	0.01 max.
Iron	0.01 max.
Sulfur	0.002 max.
Zinc	0.001 max.

Table 2 - Physical Properties

Density, g/cm ³	.89
lb/in ³	.0322
Electrical Resistivity	
At 20°C, μΩ•cm	.8
At 68°F, ohm•circ mil/ft	.48

Table 3 - Mechanical Properties

As Electroformed				
Foil Thickness, micron (inch)	10 (0.0004)	20 (0.0008)	50 (0.002)	100 (0.004)
Tensile Strength, MPa (ksi)	780 (113)	730 (106)	650 (94)	570 (83)
Elongation on 50 mm, %	0.5	1	6	9
Hardness, HV (200 g load)	-	-	195	205
Annealed				
Foil Thickness, micron (inch)	13 (0.0005)	25 (0.001)	50 (0.002)	100 (0.004)
Tensile Strength, MPa (ksi)				
Longitudinal	300 (43.5)	290 (42)	360 (52)	390 (57)
Transverse	290 (42)	290 (42)	350 (51)	360 (52)
Elongation, %				
Longitudinal	6	9	>18	28
Transverse	6	8	14	16
Hardness, HV (200 g load)	60	59	77	95

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Electroformed Nickel Foil

Corrosion Resistance

Electroformed nickel foil shows the same excellent corrosion resistance as wrought nickel in many environments. Like the wrought product, it tends to tarnish in industrial and marine atmospheres but it can be coated with conventional or microcracked chromium to reduce this tendency.

Joining

Special Metals electroformed nickel foil can be soldered and welded by the same techniques used for joining conventionally produced nickel foil.

Information on joining is available in the Special Metals publication “Joining” on the website, www.specialmetals.com.

Surface Finish

Electroforming produces one satin polished surface, the other with a smooth matt appearance. Surface roughness of the matt side depends on the thickness; typically 0.4 micron (0.0002 in) center line average for 20 micron (0.0008 in) foil.

Cold Forming

Thicker gauges show good forming characteristics without annealing, but the foil can be most readily formed if it is fully annealed. The results in Table 4 were obtained on 100 micron (0.004 in) foil using a polythene lubricant.

Table 4 - Forming Characteristics

Condition	Erichsen cup height		Maximum load	
	mm	in	N	lbf
As electroformed	3.0	0.12	830	187
Electroformed and annealed	4.4	0.17	820	185
Conventional rolled and annealed foil	4.3	0.17	1150	259

Availability

Thickness	8-100 microns (0.00031-0.004 in)
Width	Up to 500 mm (19.5 in)
Weight (in rolls)	Up to 50 kg (110 lb); e.g. approximately 1400 m at 8 microns and approximately 112 m at 100 microns

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www.specialmetals.com

U.S.A. Special Metals Corporation

Billet, rod & bar, flat & tubular products

3200 Riverside Drive
Huntington, WV 25705-1771
Phone +1 (304) 526-5100
+1 (800) 334-4626
Fax +1 (304) 526-5643



Billet & bar products

4317 Middle Settlement Road
New Hartford, NY 13413-5392
Phone +1 (315) 798-2900
+1 (800) 334-8351
Fax +1 (315) 798-2016



Atomized powder products

100 Industry Lane
Princeton, KY 42445
Phone +1 (270) 365-9551
Fax +1 (270) 365-5910



Shape Memory Alloys

4317 Middle Settlement Road
New Hartford, NY 13413-5392
Phone +1 (315) 798-2939
Fax +1 (315) 798-6860



United Kingdom

Special Metals Wiggin Ltd.

Holmer Road
Hereford HR4 9SL
Phone +44 (0) 1432 382200
Fax +44 (0) 1432 264030

ISO 9001

Special Metals Wire Products

Holmer Road
Hereford HR4 9SL
Phone +44 (0) 1432 382556
Fax +44 (0) 1432 352984



China

Special Metals Pacific Pte. Ltd.

Room 1802, Plaza 66
1266 West Nanjing Road
Shanghai 200040
Phone +86 21 3229 0011
Fax +86 21 6288 1811



Special Metals Pacific Pte. Ltd.

Room 910, Ke Lun Mansion
12A Guanghua Road
Chaoyang District
Beijing 100020
Phone +86 10 6581 8396
Fax +86 10 6581 8381



France

Special Metals Services SA

17 Rue des Frères Lumière
69680 Chassieu (Lyon)
Phone +33 (0) 4 72 47 46 46
Fax +33 (0) 4 72 47 46 59

Germany

Special Metals Deutschland Ltd.

Postfach 20 04 09
40102 Düsseldorf
Phone +49 (0) 211 38 63 40
Fax +49 (0) 211 37 98 64

Hong Kong

Special Metals Pacific Pte. Ltd.

Unit A, 17th Floor, On Hing Bldg
1 On Hing Terrace
Central, Hong Kong
Phone +852 2439 9336
Fax +852 2530 4511

India

Special Metals Services Ltd.

No. 60, First Main Road, First
Block
Vasantha Vallabha Nagar
Subramanyapura Post
Bangalore 560 061
Phone +91 (0) 80 2666 9159
Fax +91 (0) 80 2666 8918

Italy

Special Metals Services SpA

Via Assunta 59
20054 Nova Milanese (MI)
Phone +390 362 4941
Fax +390 362 494224

The Netherlands

Special Metals Service BV

Postbus 8681
3009 AR Rotterdam
Phone +31 (0) 10 451 44 55
Fax +31 (0) 10 450 05 39

Singapore

Special Metals Pacific Pte. Ltd.

24 Raffles Place
#27-04 Clifford Centre
Singapore 048621
Phone +65 6532 3823
Fax +65 6532 3621

Affiliated Companies

Special Metals Welding Products

1401 Burriss Road
Newton, NC 28658, U.S.A.
Phone +1 (828) 465-0352
+1 (800) 624-3411
Fax +1 (828) 464-8993

Canada House
Bidavon Industrial Estate
Waterloo Road
Bidford-On-Avon
Warwickshire B50 4JN, U.K.
Phone +44 (0) 1789 491780
Fax +44 (0) 1789 491781

Controlled Products Group

590 Seaman Street, Stoney Creek
Ontario L8E 4H1, Canada
Phone +1 (905) 643-6555
Fax +1 (905) 643-6614

A-1 Wire Tech, Inc.

A Special Metals Company
4550 Kishwaukee Street
Rockford, IL 61109, U.S.A.
Phone +1 (815) 226-0477
+1 (800) 426-6380
Fax +1 (815) 226-0537

Rescal SA

A Special Metals Company
200 Rue de la Couronne des Prés
78681 Epône Cédex, France
Phone +33 (0) 1 30 90 04 00
Fax +33 (0) 1 30 90 02 11

DAIDO-SPECIAL METALS Ltd.

A Joint Venture Company
Daido Shinagawa Building
6-35, Kohnan 1-chome
Minato-ku, Tokyo 108-0057, Japan
Phone +81 (0) 3 5495 7237
Fax +81 (0) 3 5495 1853