Components	wt %
Wire	
Nickel	40 – 60
Titanium	Bal.
Stop tube	
Manganese	0 – 5
Nickel	5 – 15
Chromium	10 – 25
Cobalt	0 – 1
Iron	Bal.
Plating	
Gold	0 – 100
Rhodium	0 – 100