



GMAW/GTAW NICKEL ALLOYS

AUTOMIG NiCrMo-3 / TIGFIL NiCrMo-3

NiCrMo-3 TYPE NICKEL ALLOY SOLID WIRE



CLASSIFICATION : EN ISO 18274 AWS A/SFA 5.14 **APPROVALS :**

Automig NiCrMo-3:	SNi 6625	ERNiCrMo-3	-
Tigfil NiCrMo-3:	SNi 6625	ERNiCrMo-3	IBR

KEY FEATURES :

- A low carbon Ni-Cr-Mo solid wire
- Typical 61Ni/22Cr/9Mo/3.5Nb+Ta alloy
- Suitable for cryogenic to high temperature application up to 540°C
- Exceptional resistance to pitting, crevice and stress corrosion cracking in severe chloride media
- Radiographic weld quality

WELDING POSITION :



GMAW: DCEP
GTAW: DCEN

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
GMAW: Ar or Ar/He	15-22	10-20
GTAW: Ar	10-15	-

TYPICAL APPLICATIONS :

- Joining Ni-Cr-Mo alloys
- Welding of Inconel 625, Incoloy 825, Alloy 20
- Cladding steel with Ni-Cr-Mo weld metal
- Suitable for joining ASTM B443, B444, B446 to itself, to steel, to other Ni-based alloys

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Fe	S	P	Si	Cu
Specification	0.10 max	0.50 max	5.0 max	0.015 max	0.02 max	0.50 max	0.50 max
	Al	Ti	Cr	Nb+Ta	Mo	Ni	
Specification	0.40 max	0.40 max	20.0-23.0	3.15-4.15	8.0-10.0	58.0 min	

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Typical	As Welded	760	32

Mechanical properties will vary with the type of shielding gas used.

PACKING DATA :

Automig NiCrMo-3	Ø, mm		Kg/Spool	
	0.8		12.5	
	1.2		12.5	
	1.6		12.5	
	2.0		12.5	
Tigfil NiCrMo-3	Ø x L, mm	Primary Box, Kg	No. of Primary Boxes	Net Wt. of Carton, Kg
	2.4 x 1000	5	4	20
	3.2 x 1000	5	4	20

EQUIVALENT :

SMAW Electrode: **Nicalloy Mo-3**