AUTOMIG NiCrMo-3

GMAW NICKEL ALLOYS

AWS A/SFA 5.14 ERNiCrMo-3

CLASSIFICATION:

EN ISO 18274
SNi 6625 (Ni Cr22 Mo9Nb)

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

APPROVALS: IBR

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

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Fe	Si	Cu	Al	Ti	Cr	Nb + Ta	Mo	Ni
0.10 max	0.50 max	5.0 max	0.50 max	0.50 max	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:

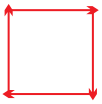
	Condition	UTS, MPa	EL%
Typical	As Welded	760	32

PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool
0.8	12.5
1.2	12.5
1.6	12.5

DCEP

All Positions



STORAGE / HANDLING :
Keep dry and follow handling instructions mentioned on the box

Shielding Gas	Gas Flow Rate, LPM
75Ar/25He	15-22