



GMAW/GTAW NICKEL ALLOYS

AUTOMIG NiCrMo-4 / TIGFIL NiCrMo-4

NiCrMo-4 TYPE SOLID WIRE



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

SNi 6276 ERNiCrMo-4 -

KEY FEATURES :

- Ni-Cr-Mo-W solid wire
- Typical 57Ni/16Cr/15.5Mo/5.5Fe/4W alloy
- Resistant to abrasion, impact, corrosion and high temperatures
- Excellent resistance to stress corrosion in reducing and oxidizing atmosphere
- 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 :

- Welding of alloy C-276 and similar composition steels
- Dissimilar joints between nickel alloys, stainless and low alloy steels
- Die plates, forge dies, hot shear blades, mandrel punches for hot working
- Suitable for joining ASTM B574, B575, B619, B622, B628 to itself, to steel, to other Ni-based alloys
- Application in chemical plants with highly corrosive conditions

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	0.02 max	1.0 max	4.0-7.0	0.03 max	0.04 max	0.08 max	0.50 max
	Co	Cr	Mo	V	W	Ni	
Specification	2.50 max	14.5-16.5	15.0-17.0	0.35 max	3.0-4.5	Bal.	

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	Hardness, HRc	
			As Welded	Work Hardened
Typical	As Welded	690	20-25	30-35

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

PACKING DATA :

Automig NiCrMo-4	Ø, mm		Kg/Spool	
	0.8		12.5	
	1.2		12.5	
	1.6		12.5	
	2.0		12.5	
Tigfil NiCrMo-4	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
	4.0 x 1000	5	4	20

EQUIVALENT :

SMAW Electrode: **Nicalloy Mo-4**