AUTOMIG NiCrMo-4

GMAW NICKEL ALLOYS

AWS A/SFA 5.14 **ERNiCrMo-4**

CLASSIFICATION:

EN ISO 18274
SNi 6276 (Ni Mo 16Cr 15Fe 6W4)

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

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

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Fe	Si	Cu	Co	Cr	Mo	V	W	Ni
0.02 max	1.0 max	4.0-7.0	0.08 max	0.50 max	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:

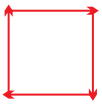
	Condition	UTS, MPa	Hardness, HRc	
			As Welded	Work Hardened
Typical	As Welded	690	20-25	30-35

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