



NICALLOY Mo-3

NON FERROUS (Ni Alloys)

AWS A/SFA 5.11 ENiCrMo-3

CLASSIFICATION:

ISO 14172

E Ni 6625 (NiCr22Mo9Nb)

IS 8736

E NiCrMo-3

KEY FEATURES:

- Basic coated electrode
- Ni based high Cr-Mo-Nb deposit
- Scale resistant in low sulphur atmosphere upto 1100°C
- Positional welding capability
- For overlay applications minimum three layers must be deposited
- Application from cryogenic to 480°C

APPROVALS: IBR/CE/ABS/LRA

TYPICAL APPLICATIONS:

- Joining and surfacing Ni alloys, austenitic steel, austenitic ferritic joints
- Welding of ASTM E163/166/167/168, Inconel 625, Incoloy 825, Alloy 20
- Overlay cladding where similar chemical composition is required on the clad side
- Suitable for material 2.4856, 1.4876

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


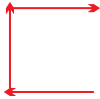
C	Mn	Si	Fe	Ni	Cr	Nb+Ta	Mo
0.025	0.30	0.5	1.0	63.5	21.5	3.5	8.75

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	760 min	30 min

Impact @-196°C-50J

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	55-75	 DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 350	90-110		
4.0 x 350	100-140		
5.0 x 350	150-210		

Available in packing of 10 kg box containing 10 plastic cartons of 1 kg each.

EQUIVALENT:

GMAW	GTAW	SAW	
		Flux	Wire
Automig NiCrMo-3	Tigfil NiCrMo-3	Automelt S76	Automelt NiCrMo-3