



## NICALLOY Mo-3

NON FERROUS (Ni Alloys)



Ni-Cr-Mo alloyed Electrode for nickel alloy Welding

**CLASSIFICATION : ISO 14172**

**AWS A/SFA 5.11**

E Ni 6625 (NiCr22Mo9Nb)

E NiCrMo-3

### KEY FEATURES :

- Basic coated electrode
- Ni based high Cr-Mo-Nb deposit
- Scale resistant in low sulphur atmosphere upto 1100°C
- Resistance to general corrosion, pitting, crevice and stress corrosion cracking in severe chloride media
- High creep strength

### WELDING POSITION :



DCEP

### 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

**REDRYING CONDITION : 250-300°C for minimum 1 hr.**

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Ni</b>	<b>Fe</b>	<b>Mo</b>
Specification	0.10 max	1.0 max	0.75 max	55.0 min	7.0 max	1 max
	<b>S</b>	<b>P</b>	<b>Cu</b>	<b>Cr</b>	<b>Nb plus Ta</b>	<b>Other</b>
Specification	0.02 max	0.03 max	0.50 max	20.0 to 23.0	3.15 to 4.15	8.0 to 11.0

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>EL%</b>
Specification	As Welded	760 min.	30 min.

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Wt./Carton, Kg</b>	<b>Cartons/Box</b>	<b>Net wt./Box, Kg</b>
2.5 x 350	45 - 70	1	10	10
3.15 x 350	80 - 100	1	10	10
4.0 x 350	90 - 130	1	10	10

**EQUIVALENT : GMAW wire: Automig NiCrMo-3**

**GTAW filler: Tigfil NiCrMo-3**