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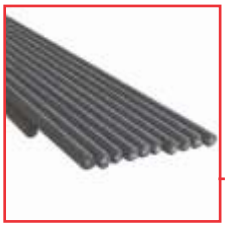

NICALLOY Mo-4

NON FERROUS (Ni Alloys)

Nickel based Welding Electrode for harsh environment application

CLASSIFICATION : ISO 14172	AWS A/SFA 5.11
E Ni 6276 (NiCr15Mo15Fe6W4)	E NiCrMo-4

KEY FEATURES :

- Basic type coating
- Resistant to abrasion, impact, corrosion and high temperatures
- Resistant to contaminated mineral acids, chloride containing media and chlorine-contaminated media
- Ni based Cr-Mo-W alloyed deposit
- Excellent resistance against Pitting and Crevice corrosion
- Can resist wet chlorine gas and strong oxidizers such as ferric and cupric chlorides

WELDING POSITION :  **DCEP**

TYPICAL APPLICATIONS :

- Welding of alloy C-276 & similar composition steels
- Suitable for material 2.4819 (NiMo16Cr15W)
- Dissimilar joints between nickel alloys, stainless and low alloy steels
- Surfacing on low alloy steels
- Application in chemical plants with highlycorrosive conditions
- For surfacing press tools, punches, forge dies, hot-stripping tools, pump rotors, valves

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Fe	S	P	Si	Other
Specification	0.02 max	1.0 max	4.0 to 7.0 max	0.03 max	0.04 max	0.2 max	0.50 max
	Cu	**Co**	**Cr**	**Mo**	**W**	**Ni**	**V**
Specification	0.50 max	2.5 max	14.5-16.5	15.0-17.0	3.0-4.5	Rem.	0.35 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Specification	As Welded	690 min.	25 min.

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
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-4 **GTAW filler: Tigfil NiCrMo-4**