



NICALLOY Mo-5

NON FERROUS (Ni Alloys)



Coated Welding Electrode depositing Ni-Cr-Mo-W alloy

CLASSIFICATION : ISO 14172

AWS A/SFA 5.11

E Ni 6275 (NiCr15Mo16Fe5W3)

E NiCrMo-5

KEY FEATURES :

- Basic coated
- Ni based Cr-Mo-W alloyed deposit
- Works smoothly with negligible spatter
- Low dilution with base metal
- Gives 150% weld metal recovery
- Reduces carbon diffusion at high temperature

WELDING POSITION :



AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- High grade welding of high Mo nickel base alloys e.g. Inconel 625/800
- Hardfacing on machine components and tools subjected to corrosion and heat
- Suitable for welding/surfacing of tong jaws of the slab handling cranes
- Joining Cr-Ni steels high in Mo Surfacing steel clad with a Ni-Cr-Mo alloy

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Fe	S	P	Si	Other
Specification	0.10 max	1.0 max	4.0 to 7.0 max	0.03 max	0.04 max	0.1 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