

WIRES FOR SUBMERGED ARC WELDING OF NICKEL & NICKEL ALLOYS



NICKEL & NICKEL ALLOY SOLID WIRES

CLASSIFICATION :	
Product	AWS A/SFA 5.14
AUTOMELT NiCr3	ERNiCr-3
AUTOMELT NiCrMo3	ERNiCrMo-3
AUTOMELT NiCrMo4	ERNiCrMo-4

KEY FEATURES :	
<ul style="list-style-type: none"> • Smooth feeding • Close dimensional tolerances 	<ul style="list-style-type: none"> • Controlled Chemistry

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :							
Product	C	Mn	Fe	Si	Cr	Mo	Other Elements
AUTOMELT NiCr3	0.01	2.80	0.4	0.15	20.0	-	Nb-2.4; Ti-0.3; Ni > 67.0
AUTOMELT NiCrMo3	0.03	0.20	4.0	0.15	22.0	9.1	Nb+Ta-3.5; Al-0.1; Ti-0.1; Ni > 62.0
AUTOMELT NiCrMo4	0.01	0.60	5.0	0.03	15.0	16.0	W-4.0; Co-0.2; Cu- 0.01

DIAMETERS - PACKING DATA :		
Product	Ø, mm	Kg / Spool
Automelt NiCr3	2.5, 3.15, 4.0, 5.0	25
Automelt NiCrMo3	2.5, 3.15, 4.0, 5.0	25
Automelt NiCrMo4	2.5, 3.15, 4.0, 5.0	25