

TIGFIL NiCr3 / AUTOMIG NiCr3

Classification

AWS A/SFA 5.14 ER NiCr-3

Characteristic

A 72Ni, 22Cr, 3 Mn, 2.5 Nb plus Ta nickel alloy wire for TIG/MIG welding of nickel-chromium-iron alloy. The alloy is suitable for application in cryogenic to high temperature range. The Weld metal has good resistance to corrosion, including oxidation resistance.

Typical Application

This wire is suitable for welding of Ni-Cr-Fe alloys. ASTM B 163 and B 166, B 167 and B 168. To join clad side of joints in steel clad with Ni- Cr-Fe alloys, surfacing steel with Ni-Cr-Fe weld metal, for dissimilar welding of Ni base alloys. Welded joints in pressure vessels, boilers, fittings, machines and apparatus construction in dissimilar alloys & on cryogenic nickel steels, for black-white joints sensitive to thermal loading above 3000C in order to prevent carbon diffusion.

Wire Chemistry

C	S	P	Mn	Si	Cr
0.10 max	0.015 max	0.03 max	2.5-3.5	0.50 max	18.0-22.0
Ni	Co	Cu	Ti	Fe	Nb+Ta
67 min	0.12 max	0.50 max	0.75 max	3.0 max	2.0-3.0

Properties of weld metal with 100% Argon gas shielding Current Condition: TIG : DC (-) MIG : DC (+)

Classifications:

All Weld Mechanical Properties As welded condition

UTS MPa

550 min

Elongation % (L=4xd)

30-35

The chemistry and mechanical properties of the weld metal will vary with the type of shielding gas used.

Packing Specifications

Supplied in D 300 plastic spools - layer wound / Weight - 15 Kg

Each plastic spool is sealed in a polyethylene bag and then packed in a corrugated box which is shrink-wrapped.

Packing Specifications for AUTOMIG NiCr3

Dia., mm	0.8	1.2	1.6	2.0
Net wt per spool,kg	12.5	12.5	12.5	12.5

Packing Data for TIGFIL NiCr3

Dia., mm	2.4	3.2
Length,mm	1000	1000
Net wt per tube,kg	5	5
No of Plastic Tubes per Box	4	4
Net wt,Box,kg	20	20



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