

TIGFIL NiCrMo3 / AUTOMIG NiCrMo3

Classification

AWS A/SFA 5.14 ER NiCrMo-3

Characteristics

A 61Ni, 22Cr, 9 Mo, 3.5 Nb plus Ta nickel alloy wire for TIG/MIG welding of nickel-chromium-iron alloy. The alloy is suitable for application having operating temperature ranging from cryogenic to 540°C. Weld metal is having exceptional corrosion resistance.

Typical Application

This wire is suitable for welding of Ni-Cr-Mo alloys. ASTM B 443 and B 466, to itself, to steel and to other Ni base alloys. For cladding of steel with Ni-Cr-Mo weld metal and for welding clad side of joints in steel with Ni-Cr-Mo alloy.

Wire Chemistry

| C | S | P | Mn | Si | Cr | Ni |
|----------|-----------|----------|----------|-----------|-----------|----------|
| 0.10 max | 0.015 max | 0.02 max | 0.50 max | 0.50 max | 20.0-23.0 | 58.0 min |
| Mo | Cu | Ti | Fe | Nb+Ta | Al | |
| 8.0-10.0 | 0.50 max | 0.40 max | 5.0 max | 3.15-4.15 | 0.40 max | |

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 760 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 NiCrMo3

| | | | | |
|---------------------|------|------|------|------|
| 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 NiCrMo3

| | | |
|-----------------------------|------|------|
| 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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