

# TIGINOX NiCrMo 4 / AUTOMIG NiCrMo 4

## Classification

AWS A/SFA 5.14 : ER NiCrMo-4

## Characteristic

A 57Ni, 16Cr, 15.5 Mo, 5,5 Fe, 4 W nickel alloy wire for TIG/MIG welding of nickel-chromium-iron alloy. This alloy offers excellent resistance to stress corrosion resistance in reducing and in oxidizing atmosphere.

## Typical Application

This wire is suitable for the welding of Ni-Cr-Mo alloys, ASTM B 574, B 575, B 619 and B 622, to itself, to steel and to other Ni base alloys. For cladding of steel with Ni-Cr-Mo weld metal. Die plates, forge dies, hot shear blades, mandrel punches for hot working.

## Wire Chemistry

C	S	P	Mn	Si	Cr	Ni
0.02 max	0.03 max	0.04 max	1.0 max	0.08 max	14.5-16.5	Balance
Mo	Cu	W	Fe	V	Al	Co
15.0-17.0	0.50 max	3.0-4.5	4.0-7.0	0.35 max	0.40 max	2.5 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	690
Hardness	As welded      20-25 Rc
	Work Hardened      30-35 Rc

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 - 12.5 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 NiCrMo 4

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 NiCrMo 4

Dia., mm	1.6	2.0	2.5	3.2	4.0
Length,mm	1000	1000	1000	1000	1000
Net wt per tube,kg	5	5	5	5	5
No of Plastic Tubes per Box	4	4	4	4	4
Net wt,Box,kg	20	20	20	20	20



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