

❖ Product Description

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|---|---|
| I. A low alloy carbon Ni-Cr-Mo solid wire | IV. Exceptional resistance to pitting, crevice and stress corrosion cracking in severe chloride media |
| II. Typical alloy 61Ni/22Cr/9Mo/3.5Nb+Ta alloy | V. Radiographic weld quality |
| III. Good for both cryogenic and elevated temperature application | |

❖ Range of Application

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| I. For joining Ni-Cr-Mo alloys | III. For cladding steel with Ni-Cr-Mo weld metal |
| II. Suitable for welding of Inconel625, Incoloy 825, alloy 20 | IV. Good for joining ASTM B443, B444, B446 to itself, to steel, to other Ni-based alloys |

❖ Classification

- AWS/SFA 5.14 ERNiCrMo-3

❖ % Chemical Composition

Type of Wire		C	Mn	Fe	S	Si	Cu	P	Ni	Al	Ti	Cr	Na+Tb	Mo	Other Elements
ERNiCrMo-3	Min	-	-	-	-	-	-	-	58.0	-	-	20.0	3.15	8.0	-
	Max	0.10	0.50	5.0	0.015	0.50	0.50	0.02	-	0.40	0.40	23.0	4.15	10.0	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
As Welded	760	-	32	-

❖ Wire Size & Welding Position

- Diameter in mm- 1.60, 2.00, 2.40, 3.20, 4.00, 5.00.
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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