

❖ Product Description

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| I. A low alloy carbon Ni-Cr-Mo-W solid wire | IV. Excellent resistance to stress corrosion in reducing and oxidizing atmosphere |
| II. Typical alloy 57Ni/16Cr/15.5Mo/5.5Fe/4W alloy | V. Radiographic weld quality |
| III. Good resistance against abrasion, impact, corrosion and high temperatures | |

❖ Range of Application

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| I. For welding of alloy C-276 and similar composition steels | III. Die plates, forge dies, hot shear blades, mandrel punches for hot working |
| II. Good for dissimilar joints of Ni alloys, stainless and low alloy steels | IV. Application with chemical plants with highly corrosive conditions |

❖ Classification

- AWS/SFA 5.14 ERNiCrMo-4

❖ % Chemical Composition

Type of Wire		C	Mn	Fe	S	Si	Cu	P	Ni	Co	Cr	V	W	Mo	Other Elements
ERNiCrMo-4	Min	-	-	4.0	-	-	-	-	-	-	14.5	-	3.0	15.0	-
	Max	0.02	1.0	7.0	0.03	0.08	0.50	0.04	Bal	2.50	16.5	0.35	4.5	17.0	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ -30°C
As Welded	690	-	-	-

❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- 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: -

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| (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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