

ERNiCr-3

AWS A5.14 ERNiCr-3

Description:

ERNiCr-3 is used for joining base materials such as UNS number N06600, including ASTM grades B163, B166, B167, and B168. It can also be used for dissimilar welding using various nickel alloys to stainless steels or carbon steels, as well as for overlaying carbon steels.

The weld bead has high strength and good corrosion resistance, with oxidation resistance and creep rupture strength at elevated temperatures.

Diameters:

1.2/1.6mm

Typical Mechanical Properties:

Tensile strength(MPa):	580
Yield strength(MPa):	360
Elongation(%):	36
Impact values(≥ 47)/(-20°C):	—

Typical Chemical Composition:

C	Mn	P	S	Si	Ni	Cu	Cr
0.02	2.9	0.006	0.003	0.05	70.5	0.009	20.5

Welding Current:(DC+)

Diameter(mm)	1.2	1.6
Current/A	75-160	120-300
Voltage/V	19-22	20-32
Gas speed/(L/Min)	20-25	20-25

Note:

1. Rusty, water, oil and other impurity should be cleaned before welding.
2. Use 75% Ar+25% He as shielding gas