

ERNiCrMo-3

AWS A5.14 ERNiCrMo-3

Description:

It is a Ni-Cr-Mo type welding wire used to weld Ni-Cr-Mo alloys like N06625 and inconel625. The deposited metal has high strength and great anti-corrosion performance,

Diameters:

1.2/1.6mm

Typical Mechanical Properties:

Tensile strength(MPa):	778
Yield strength(MPa):	455
Elongation(%):	30
Impact values(≥ 47)/(-20 °C):	-

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Nb	Cu	Ti
0.090	0.25	0.016	0.012	0.005	60.5	22.1	8.4	3.35	0.08	0.07

Welding Current:(DC+)

Diameter(mm)	1.2	1.6
Current/A	120-220	180-300
Voltage/V	20-32	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