

ERNiCrMo-4

AWS A5.14 ERNiCrMo-4

Description:

ERNiCrMo-4 is used for welding nickel-chromium-molybdenum base materials (ASTM B574, B575, B619, B622, and B626) to itself, steel and other nickel base alloys and for cladding steel.

Diameters:

1.2/1.6mm

Typical Mechanical Properties:

Tensile strength(MPa):	740
Yield strength(MPa):	455
Elongation(%):	42
Impact values(≥ 47)/(-20 °C):	-

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Co	Cu	W
0.014	0.50	0.016	0.012	0.005	57.6	16.1	16.3	0.40	0.08	3.30

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