

CLASSIFICATION:

AWS 5.14 Class ERNiCrMo-10 ASME SFA 5.14 Class ERNiCrMo-10

DESCRIPTION

Nickel- alloy bare wire is used for GMAW, GTAW.

SHELDING GAS

GMAW: Ar or Ar /He

GTAW: Ar

APPLICATIONS

Welding of steels with similar chemical composition as well as dissimilar materials of nickel base alloys, steels and stainless steels. Excellent resistance to stress corrosion cracking, pitting, and crevice corrosion, thus it is often used for cladding

CHEMISTRY OF WELD METAL – TYPICAL (PERCENT)

C	Mn	Fe	P	S	Si	Cu	Ni	Co	Cr
0.015 Max	0.50 Max	2.0-6.0	0.02 Max	0.01 Max	0.08 Max	0.50 Max	Rem	2.50 Max	20- 22.5
Mo	V	W							
12.5- 14.5	0.35 Max	2.5-3.5							

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

Condition	UTS, MPa	EL %
As welded	690	38

PRODUCT FORM

Mig Spool :1.20mm dia x 12.5 kg

Tig : 2.4mm dia. X 1000 mm
1.60 mm dia x 1000mm

EWAC Alloys Limited

Registered Office:

AFL House, Lok Bharti Complex, Fifth floor (West Side), Marol- Maroshi Road, Andheri East, Mumbai - 400059, India.
Tel: +91 22 68509285 | Fax: +91 22 68509876 | Email: enquiry@ewacalloys.com | Website : www.ewacalloys.com
CIN: U74999MH1962PLC012315