

Swastik Weld Make Welding Wire GMAW/GTAW (MIG & TIG) for Nickel Alloy Wire

III) ER NiCrMo-3 CLASSIFICATION : AWS A/SFA 5.14

Chemical Composition of ER NiCrMo-3 Wire

C=0.10 max

Mn= 0.50 max

Fe= 5.0 max

S= 0.015 max

P= 0.02 max

Si= 0.50 max

Cu= 0.50 max

Al= 0.40 max

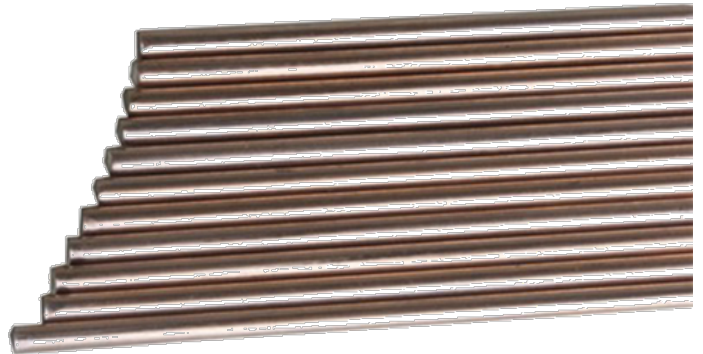
Ti= 0.40 max

Cr= 20.0-23.0

Nb + Ta= 3.15-4.15

Mo= 8.0-10.0

Ni= 58.0 min



MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS, Mpa= 760

EL%= 32

TYPICAL APPLICATION OF ER NiCrMo-3 (Inconel 625 Wire):

1) A low carbon Ni-Cr-Mo solid wire for Joining Ni-Cr-Mo alloys (Welding of Inconel alloys 22, 622 and 625, Incoloy alloy 25-6MO, and Incoloy alloy 825

2) Suitable for Joining ASTM B443, B444, B4446 to itself, to steel, to other Ni-Bases alloys

3) Application in pressure vessels, boilers, fittings, machines and apparatus constructions

Packing: Tig: In cut length of 1000mm in 5kgs boxes (size: 1.6, 2.0, 2.40, 3.15mm)

Mig: Continuous wire in 12.5kgs / 15kgs Plastic Spool (size: 0.80, 1.2mm)

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