

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

IV) ER NicRMo-4 CLASSIFICATION : AWS A/SFA 5.14

Chemical Composition of ER NiCrMo-4 Wire

C=0.02 max

Mn= 1.0 max

Fe= 4.0-7.0

S= 0.03 max

P= 0.04 max

Si= 0.08 max

Cu= 0.50 max

Co= 2.50max

Cr= 14.5-16.5

Mo= 15.0-17.0

V= 0.35 max

W= 3.05-4.5

Ni= Bal.



MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS, Mpa= 690

Hardness= 20-25

TYPICAL APPLICATION OF ER NiCrMo-4 (Hastelloy C 276 Wire)

1) Typical Ni-Cr-Mo-W solid wire for welding of alloy C-276 and similar composition steels

2) Die plates, forge dies, hot shear blades, mandrel punches for hot working

3) Application in Chemical plants with highly corrosive conditions

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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