

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

II) ER NiCr-3 CLASSIFICATION : AWS A/SFA 5.14

Chemical Composition of ER NiCr-3 Wire

C=0.10 max

Mn= 2.5-3.5

Fe= 3.0 max

S= 0.015 max

P= 0.03 max

Si= 0.50 max

Cu= 0.50 max

Co= 0.12 max

Ti= 0.75 max

Cr= 18.0-22.0

Nb + Ta= 2.0-3.0

Ni= 67.0 min



Mechanical Properties Of All Weld Metal :

UTS, Mpa= 550

EL%= 33

TYPICAL APPLICATION OF ER NiCr-3 (Inconel 82 Wire):

- 1) A low carbon Ni-Cr solid wire for welding of Ni-cr-Fe alloys (Inconel alloys 600, 601 and 690, Incoloy alloys 800 and 800HT, and Incoloy alloys 330)
- 2) Dissimilar welding of Ni based alloys and cladding Incoloy alloys and incoloy alloy 330 to nickel, Monel alloys, stainless steels, and steels. It is also used to join stainless steel to nickel alloys and carbon steels
- 4) Joining Steels to stainless steels or Ni based alloys
- 5) 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)

Works: Gala No. 19, Syndicate Indl. Complex, Near Golani Naka, Near Bank of Maharashtra, Wallive Road, Vasai (E), Dist. Thane - 401 208.

Email: swastikweld@gmail.com

Mobile: +91 9321434296, www.swastikweld.com