

# AUTOMIG NiCr-3

AWS A/SFA 5.14 ERNiCr-3

GMAW NICKEL ALLOYS

## CLASSIFICATION:

EN ISO 18274

SNi 6082 (NiCr 20Mn 3Nb)

## KEY FEATURES:

- A low carbon Ni-Cr solid wire
- Typical 72Ni / 20Cr / 3Mn / 2.5Nb+Ta alloy
- Suitable for cryogenic to high temperature application
- High corrosion and oxidation resistance
- Excellent toughness at low temperatures
- Radiographic weld quality

**APPROVALS:** IBR

## TYPICAL APPLICATIONS:

- Welding of Ni-Cr-Fe alloys
- Dissimilar welding of Ni based alloys and cladding
- For joints sensitive to thermal loading above 300°C to prevent carbon diffusion
- Joining steels to stainless steels or Ni based alloys
- Applications in pressure vessels, boilers, fittings, machines and apparatus constructions

## TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:


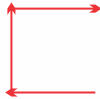
C	Mn	Fe	Si	Cu	Al	Ti	Cr	Nb + Ta	Ni
0.10 max	2.5-3.5	3.0 max	0.50 max	0.50 max	0.12 max	0.75 max	18.0-22.0	2.0-3.0	67.0 min

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	550	33

Mechanical properties will vary with the type of shielding gas used.

## PARAMETERS - PACKING DATA:

∅, mm	Kg/Spool		
1.2	12.5	 <b>DCEP</b>	All Positions, Except Vertical Down: 
1.6	12.5		
		<b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box	

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
Ar	10-15	-