



TIGFIL NiCr-3

GMAW/GTAW NICKEL ALLOYS

AWS A/SFA 5.14 ERNiCr-3

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



CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Fe	Si	Cu	Co	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

PARAMETERS - PACKING DATA:

Ø, mm	Net Wt., Kg		
2.0 x 1000	20	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions 
2.4 x 1000	20		
3.15 x 1000	20		

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

Available in Standard carton packing of 20 kg box, containing 4 plastic tubes of 5 kg each.