

greenTECHNiCrMo3

ISO OERLIKON AG Schweisstechnik

CH-5737 Menziken AG – Tel. +41 (0)62 771 83 05

E-Mail info@iso-oerlikon.ch – www.iso-oerlikon.ch

Comparable specifications

ASME SFA A 5.14: ERNiCrMo-3

EN ISO 18274: Ni 6625 - NiCr22Mo9Nb

BS 2901: Pt 5 NA 43

Werkstoff Nr.: 2.4831

Description and applications*

* Illustrative, not-exhaustive list

This grade may be used for:

- welding of nickel-chromium-molybdenum alloys to themselves, to steel a/o to other nickel base alloys;
- cladding of steel with nickel chromium-molybdenum weld metal;
- welding of the clad side of joints in steel with nickel-chromium-molybdenum alloy;
- joining of other nickel alloys where micro-fissuring is problematic;
- applications in the chemical process industry, in marine engineering and within pollution control equipments;
- applications where the operative temperature ranges from cryogenic to 540°C;
- use in high-grade plant/engineering (primarily for the petro-chemical industry).

Weldable base materials*

* Illustrative, not-exhaustive list

Inconel 601, Incoloy 800, Alloy 625, Alloy 825, Alloy 926

All-weld metal mech. properties*

* For reference only values

Tensile strength (Rm): $\geq 760 \text{ N/mm}^2$

Elongation: $\geq 35\%$

Yield Strength (Rp_{0.2}): $\geq 415 \text{ N/mm}^2$

Charpy-V Impact (R.T.): $\geq 100 \text{ J}$

Chemical composition*

* For reference only values

C	Mn	Fe	P	S	Si	Cu	Ni	Co	Al	Ti	Cr	Nb+Ta	Mo
max	max	max	max	max	max	max	60.00	max	max	max	20.00	3.15	8.00
0.10	0.50	0.50	0.015	0.015	0.50	0.50	min	1.00	0.40	0.40	23.00	4.15	10.00

Standard packaging data*

Welding process	Product type	Ø mm (inches)	Packing type	Weight kg (lbs)	Length mm (inches)
GMAW **	filler wire	0.80 - 1.20 (0.030 - 0.047)	spools BS300 / D300	15 (33)	n.a.
GTAW **	filler rod	1.60 - 4.00 (1/16 - 5/32)	cardboard boxes / tubes	5 (11)	1000 (39.4)
SAW **	filler wire	1.60 - 4.00 (1/16 - 5/32)	basket rims B450	25 (55)	n.a.

* Other sizes and packing types are available upon request

** GMAW: gas metal arc welding; GTAW: gas tungsten arc welding; SAW: submerged arc welding

Marking

Each filler rod for GTAW welding is durably marked with an identification traceable to the unique product type. Welding filler materials wound on spools or in coils are durably marked on the coil or spool with an identification traceable to the unique product type.

The outside of each unit package is suitably labelled with at minimum the following data: grade, diameter, heat, lot no., classifications.

Customized labels are available upon request.

Type approvals

TUV Nord Kennblatt nr. 06081 (GMAW) **TUV Nord** Kennblatt nr. 06082 (GTAW)

TUV Nord Kennblatt nr. 06195 (SAW)

ABS Cert. nr. GE2672243-X1 (GMAW Ø 1.20mm / 0.047")

Lot classification

All our productions fulfil the **Class S3** requirements acc. to EN ISO 14344.