

MILL TEST CERTIFICATE

NiCrMo-3

CATEGORY: GMAW-GTAW Solid MIG welding wires

TYPE: NiCrMo-3 is a Nickel-Chromium-Molybdeum alloyed round welding wire

APPLICATIONS: NiCrMo-3 is developed for welding and cladding nickel-based alloys such as alloy NiCr22Mo9Nb or similar materials. This alloy can also be used for welding dissimilar nickel-based alloys to each other, to alloyed steels or to stainless steels and for joining 6% molybdenum super austenitic steels.. NiCr22Mo9Nb is most commonly used in the chemical processing industry, pollution control equipment, marine equipment, nuclear reactor components, pump shafts. Also used in the aerospace industry for thrust reverse assemblies, fuel nozzles, after-burners and combustion systems.

PROPERTIES: NiCrMo-3 is a solid drawn wire that is cleaned in a very special way to obtain cleaner and higher quality welds, especial- ly when used for the Hot wire Tig process intermediate cleaning between the layers can be skipped and results in a bright seam with excellent ductility. The cast and helix of this wire are kept above the EN standards to offer excellent wire feeding and a wire that comes straight out of the torch.

CLASSIFICATION:

AWS A 5.14: ER NiCrMo-3 | EN ISO 18274: S Ni 6625 (NiCr22Mo9Nb)


DIN: W.Nr. 2.4831 | DIN 1736: SG NiCr21Mo9Nb

SUITABLE FOR: NiCrMo-3 is developed for welding and cladding nickel-based alloys such as alloy 625, 825 or similar materials. This alloy can also be used for welding dissimilar nickel-based alloys to each other, to alloyed steels, to stainless steels and for joining 9% Nickel steels., X10NiCrAlTi, 32-20H, 32-21, X8 Ni9, ASTM A 533 Gr1, 800H, NiCr21Mo, NiCr22Mo9Nb DIN W.Nr.:1.5656, 1.4529, 2.4858, 2.4856, 1.4539,1.4547, 2.4660..

WELDING POSITIONS:



TYPICAL WELD DEPOSIT WEIGHT % :

Dia (mm)	Chemical Composition (%)								
	C	Si	Mn	Cr	Mo	Nb+Ta	Ti	Fe	Ni
	0.002	0.05	0.02	22.19	9.58	3.65	0.162	0.4	Remains
2.0	Melting metal mechanical performance								
	RP0,2 (N/mm ²)	Rm (N/mm ²)	A5 %	Impact Energy (J) ISO-V +20°C -40°C -196°C					
	>460	>750	>32	>110	>70				

Quality Control Stamp

Date: March-20,2019