

LNM NiCro 60/20

CLASSIFICATION

AWS A5.14/A5.14M - ERNiCrMo-3

ISO 18274 - S Ni 6625 (NiCr22Mo9Nb)

GENERAL DESCRIPTION

Solid wire for welding of nickel alloys
 Extreme resistance to various corrosion forms
 High chromium and molybdenum content

WELDING POSITIONS

ISO/ASME						
	PA/1G	PB/2F	PC/2G	PD/4F	PE/4G	PF/3G up

SHIELDING GASES (ACC. ISO 14175)

I1	Inert gas Ar (100%)
I3	Inert gas Ar+ 0.5-95% He

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni	Cr	Mo	Nb	Fe
0.02	0.06	0.07	64	21.9	9	3.5	0.4

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
						+20°C	-196°C
Typical values	I1	AW	520	770	34	80	60

MATERIALS TO BE WELDED

Ni-alloy grades	DIN/EN	Mat. Nr	ASTM/ACI	UNS
NiCrMo-steel type alloy 625 and welding dissimilar high NiCrMo-steels for corrosion and heat resisting purposes				
	X1NiCrMoCuN25-20-6	1.4529	Alloy 925	N08925
	X1NiCrMoCu25-20-5	1.4539	Alloy 904L	N08904
	X1CrNiMoCuN20-18-7	1.4547	Alloy 254	S31254
	X2NiCrAlTi32-20	1.4558	Alloy 800L	N08800
	G-X10NiCrNb32-20	1.4859		
	X10NiCrAlTi32-20	1.4876	Alloy 800/800H	N08800/-10
	NiCr22Mo6Cu	2.4618	Alloy G	N06007
	NiCr22Mo7Cu	2.4619	Alloy G-3	N06985
	NiCr21Mo6Cu	2.4641	Alloy 825hMo	N08821
	NiCr20CuMo	2.4660	Alloy 20	N08020
	NiCr15Fe	2.4816	B168-Alloy 600	N06600
	NiCr22Mo9Nb	2.4856	B443-Alloy 625	N06625
	NiCr21Mo	2.4858	B424-Alloy 825	N08825
	NiCr20Ti	2.4951	Alloy 75	N06075
	NiCr20TiAl	2.4952	Alloy 80A	N07080
Low alloyed steels	10Ni14 (3.5% Ni)	1.5637	ASTM A333 Grade 3	-
	12Ni19, X12Ni5	1.5680	-	K41583
9% Ni-steel for LNG storage tanks	X8Ni9	1.5662	A353/A353M	-
	X8Ni9 / 8%Ni	1.5662	A553/A553M Type I/II	- / K71340

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	1.0	1.2	1.6
Unit : 15 kg spool BS300	X	X	X	X
Other sizes and packaging on request				

LNM NiCro 60/20: rev. EN 22