

NIROD 600

TOP FEATURES

- Used for 3%, 5% and 9% nickel steels to give good strength and toughness in LPG and LNG processing or storage plant. In sulphurous atmosphere the weld metal can be used <500°C
- Used for joining ferritic to austenitic steels (dissimilar) with operating temperatures or postweld heat treatment higher than 300°C.
- Even at higher temperatures there is only limited carbon diffusion in the weld metal thus avoiding crack-prone carbide commissures in the weld interface of dissimilar joints.

TYPICAL APPLICATIONS

- Cryogenic Applications
- Cladding
- Nuclear Power generation
- Petrochemical
- Dissimilar joints

CLASSIFICATION

AWS A5.14 ER NiCr-3
EN ISO 18274-A S Ni 6082 (NiCr20Mn3Nb)

SHIELDING GASES (ACC. EN ISO 14175)

I1 Inert gas Ar (100%)

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	P	S	Cr	Nb	Fe	Ti	Ni
0.050	3	0.3	≤0.020	≤0.015	20	2.5	2	0.5	Rest

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						+20°C	-196°C
Typical values	I1	AW	≥380	≥620	≥35	≥100	≥55

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Weight (kg)	Item number
2.0	PE Tube	5.0	W000283539
2.4	PE Tube	5.0	W000283540

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.