

20.70.Nb

TOP FEATURES

- MIG wire welding of nickel base alloys and dissimilar joints between nickel alloys, ferritic and austenitic stainless steels.
- Hot cracking resistance
- Tolerance to high dilution

CLASSIFICATION

AWS A5.14

ERNiCr-3

EN ISO 18274-A

S Ni6082

SHIELDING GASES (ACC. EN ISO 14175)

I1

Inert gas Ar (100%)

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

	C	Mn	Si	S	P	Cr	Ni	Nb	Cu	Ti	Fe
Min.		2.5				18.0	67.0	2.0			
Max.	0.05	3.5	0.50	0.015	0.020	22.0	bal.	3.0	0.50	0.7	3.0
Typical	0.02	3	0.1	0.005	0.01	20	73	2.5	0.01	0.4	1

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Typical values as welded		RT
Tensile strength	(MPa)	640
0.2% Proof strength	(MPa)	390
Elongation (%)	4d	35
Reduction of area (%)		50
Impact ISO-V (J)	-196° C	> 60

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (S300)	15.0	M2070NB-10
1.2	SPOOL (S300)	15.0	M2070NB-12

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.