

EPRI P87

MIG (GMAW)

SOLID WIRE FOR MIG

PRODUCT DESCRIPTION

Solid wire for MIG welding.

CLASSIFICATIONS

No current national standards but covered by U.S Patent 7,562,807.

ASME IX QUALIFICATION

QW432 F-No --

CHEMICAL COMPOSITION (WIRE WT %)

|         | C   | Mn  | Si  | S     | P     | Cr | Ni  | Mo | Nb | Fe |
|---------|-----|-----|-----|-------|-------|----|-----|----|----|----|
| Typical | 0.1 | 1.5 | 0.3 | 0.008 | 0.008 | 9  | Bal | 2  | 1  | 38 |

ALL-WELD MECHANICAL PROPERTIES

|                           |         |
|---------------------------|---------|
| As welded                 | Typical |
| Tensile strength [MPa]    | 560     |
| 0.2% proof strength [MPa] | 360     |
| Elongation [%] 4d         | 32      |
| Impact ISO [J]            | 150     |

TYPICAL OPERATING PARAMETERS

| Shielding gas | Current | Diameter (mm) | Parameters |
|---------------|---------|---------------|------------|
| Argon         | DC-     | 2.4           | 100A, 12V  |

PACKAGING DATA

| Diameter (mm) | Weight (kg) | Packaging | Item number |
|---------------|-------------|-----------|-------------|
| 0.9           | 12.5        | S300      | MEPRIP87-09 |

FUME DATA (WT % TYPICAL)

| Fe | Mn | Ni | Cr  | Cu   | F  | OES [mg/m³] |
|----|----|----|-----|------|----|-------------|
| 9  | 5  | 6  | 2.5 | <0.5 | 12 | 2           |

NICKEL BASE ALLOYS