LNM NiCroMo 60/16

CLASSIFICATION

AWS A5.14/A5.14M - ERNiCrMo-4
ISO 18274 - S Ni 6276 (NiCr15Mo16Fe6W4)

GENERAL DESCRIPTION

Solid wire for welding CrMoW-alloyed nickel alloys (e.g. Alloy C276)
Depending on the corrosion requirements also applicable for welding C-22 and C-4
Extreme resistance to corrosion environments containing sulphuric acid and chlorides
Applicable for surfacing in high temperature applications (up to 1200°C)

WELDING POSITIONS

ISO/ASME

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	W	Fe
0.006	0.5	0.04	58	16	16	3.6	5.8

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm^2)	Tensile strength (N/mm^2)	Elongation (%)	Impact ISO-V(J) +20°C
Typical values	I1	AW	400	700	25	90

MATERIALS TO BE WELDED

Ni-alloy grades	DIN/EN	Mat. Nr.	ASTM/ACI	UNS
Ni Base high CrMo steel for high corrosion environments				
	NiMo 16Cr15W	2.4819	C-276	N10276
	NiCr21Mo14W	2.4602	C-22	N06022
	NiMo 16Cr16Ti	2.4610	C-4	N06455

- LNT/LNM NiCroMo 60/16 is developed for welding C-276 material
- Can also be applied for welding C-22 and C-4, depending on the corrosion requirements

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	0.9	1.0	1.2	1.6
Unit : 15 kg spool BS300	X	X	X	X	X

Other sizes and packaging on request