62-50 TIG

CLASSIFICATION

AWS A5.14M	ERNiCrMo-3
EN ISO 18274-A	S Ni6625

SHIELDING GASES (ACC. EN ISO 14175)

I1	Inert gas Ar (100%)

APPROVALS

DNV	TÜV
+	+

CHEMICAL COMPOSITION (WEIGHT %), WIRE

	C	Mn	Si	S	P	Cr	Ni	Mo	Nb	Cu	Al	Ti	Fe
Min.						20.0	60.0	8.0	3.15				
Max.	0.05	0.50	0.50	0.015	0.015	23.0	bal.	10.0	4.15	0.50	0.40	0.40	1.0
Typical	0.015	0.02	0.05	0.004	0.004	22	65	9	3.5	0.05	0.2	0.2	0.2

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Typical values as welded		RT	165°C
Tensile strength	(MPa)	775	710
0.2% Proof strength	(MPa)	500	440
Elongation (%)	4d	42	42
	5d	40	40
Reduction of area (%)		55	
Impact ISO-V (J)	-196°C	140	
Hardness, cap/mid	(HV)	205/225	

Cannot meet TS > 827MPa required by cold rolled ASTM N06625 Grade 1, but meets PS > 414MPa and properties of hot rolled grades. Cast CW-6MC solution annealed 1175°C + WQ requires TS > 485MPa.

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Weight (kg)	Item number
1.6	PE Tube	2.5	T6250-16
2.0	PE Tube	5.0	T6250-20
2.4	PE Tube	5.0	T6250-24
3.2	PE Tube	2.5	T6250-32

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.