



Nickel/Alloy Filler Wire

AWS A5.14 ER NiCr-3
BS 2901 Pt5: NA 35
DIN 1736 SG NiCr20Nb 2.4806

NW-1720

DESCRIPTION & APPLICATION

Nickel Alloy Filler Wire for the joining and surfacing of Alloys of a similar composition, (Inconel 600) Also suitable for the joining of these Alloys to steel, Copper/Nickel and other Nickel alloys. Used in high-grade plant/engineering primarily for the Petro-chemical industry.

BASE MATERIALS

Inconel 600
Nicrofer 6023, Nicrofer 7216, 7216H, 7216LC
Nimonic 75

MECHANICAL PROPERTIES

>620 UTS n/mm	>380 YIELD 0.2%	>35 ELONG A5%	-196°C. >100 CHARPY (J)
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METAL WELD COMPOSITION %

C	Si	Mn	Cr	Ni	Nb	Fe	Cu	Ti
0.013	0.08	3.0	20.0	BAL	2.4	0.9	0.015	0.5

PACKAGING

15kg Spools (MIG)
5kg Tubes (TIG)

DIAMETERS

0.8, 1.0, 1.2mm (MIG)
1.6, 2.4, 3.2mm (TIG)

WELDING INSTRUCTIONS

Thorough cleaning of the weld zone is paramount. 100% Argon gas for TIG applications, Argon/Helium or Argon for MIG or proprietary special gases. Do not overheat. Prior to welding, all traces of paint, oil, grease or other sources of hydrocarbons to be removed.