



AWS A5.14 ER NiCrMo-3
 BS 2901 Pt5: NA 43
 Werkstoffe No 2.4831 Din 1736 NiCr21Mo9Nb

Nickel/Chrome/Moly Filler Wire

NW-1740

DESCRIPTION & APPLICATION

Nickel Alloy Filler Wire for the joining and surfacing of Alloys of a similar composition, (Inconel 625) Also suitable for the joining of these Alloys to steel, copper/nickel and other Nickel alloys. Overlay of forging dies. Used in high-grade plant/engineering primarily for the Petro-chemical industry. Can be used to join other Nickel alloys, such as alloy 825, where Micro-fissuring is problematic.

BASE MATERIALS

Inconel 625	Alloy 800H, 825
Nicrofer 6020h Mo, Nicrofer 4221h Mo	Alloy 601

MECHANICAL PROPERTIES

>750 UTS n/mm	>450 YIELD 0.2%	>40 ELONG A5%	-196°C. >80 CHARPY (J)
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METAL WELD COMPOSITION %

C	Si	Mn	Cr	Ni	Mo	Nb	Ta	Fe
0.02	0.1	0.02	22.0	BAL	9.0	3.5	3.5	<10

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.