



AWS A5.14 ER NiCrMo-4
 BS 2901 Pt5: NA 48
 Werkstoffe No 2.4887

Nickel/Chrome/Moly Filler Wire

NW-1760

DESCRIPTION & APPLICATION

Nickel Alloy Filler Wire for the joining and surfacing of Alloys of a similar composition, (HASTELOY C276) Also suitable for the joining of this Alloy to other Nickel alloys. Used in high-grade plant/engineering primarily for the Petro-chemical industry. Highly resistant to sulphurous environment.

BASE MATERIALS

Hastelloy C276

MECHANICAL PROPERTIES

>720 UTS n/mm	>430 YIELD 0.2%	40 ELONG A5%	+20°C. >65 CHARPY (J)
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METAL WELD COMPOSITION %

C	Si	Mn	Cr	Ni	Mo	Fe	W
0.004	0.05	0.5	16.0	58.0	16.0	6.0	3.5

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.