

# Welding Wire Corrosion Resistant Nickel Chrome Alloy Incoloy 825 Wire

14.

Basic Information		
• Place of Origin:	China	
<ul> <li>Brand Name:</li> </ul>	Victory	
Certification:	CE,ROHS,ISO 9001	
Model Number:	ERNiCrMo-3,ERNiCrMo-4,ERNiCrMo- 13,ERNiCrFe-7,ERNiCr-3	
Minimum Order Quantity:	15	
Packaging Details:	Spool package with Carton box, Coil package with polybag	
<ul> <li>Delivery Time:</li> </ul>	5-21 days	
<ul> <li>Payment Terms:</li> </ul>	L/C, T/T, Western Union, MoneyGram	
<ul> <li>Supply Ability:</li> </ul>	300 tons per month	
Product Specification		
Material:	Ni, Mo, Cr	\7 <i>E//</i> =
<ul> <li>Elongation:</li> </ul>	≥22 %	V#\_
<ul> <li>Density:</li> </ul>	8.60 G/cm3	
<ul> <li>Tensile Strength Rm N/mm<sup>2</sup>:</li> </ul>	≥600	HAR Seed



• Yieldstrength R P0. 2

N/mm<sup>2</sup>:

• Highlight:

Melting Point:Certificates:

≥360

1310-1360°C

A5.14 nickel base alloy

AWS A5.14 / ASME SFA A5.14

Welding Nickel Wire, 1.6mm nickel wire,



# **Product Description**

# ASME SFA A5.14 ERNiCrMo 13 1.6mm Nickel Welding Wire

ERNiCr-3 nickel alloy bare wire is used for GMAW, GTAW, and SAW Nickel Alloy welding. It is used for joining base materials such as UNS number N06600. This includes ASTM grades B163, B166, B167, and B168. This alloy can also be used for dissimilar welding using various nickel alloys to stainless steels or carbon steels, as well as for overlaying carbon steels. Also used for welding 9% nickel steels to one another having high impact strength at low temperatures. This versatile alloy has high strength and good corrosion resistance, with oxidation resistance and creeprupture strength at elevated temperatures.

### Nickel Based Welding Wire

Nickel alloy welding wire ERNiCrMo-13 is a nickel-chromiummolybdenum alloy with extra low carbon and silicon contents. It offers excellent corrosion resistance, high mechanical strength, and better thermal stability. Because of its low silicon and carbon contents and no tungsten, Pinnacle Alloys ERNiCrMo-13 is not prone to grain-boundary precipitation during hot forming and welding. Pinnacle Alloys ERNiCrMo-13 is well suited for welding in a wide variety of chemical processing facilities in both oxidizing and reducing media. This wire provides exceptional weldability and very low sensitivity to hot cracking.

It is designed to match the nickel base alloy commonly known as alloy 59. The high level of Mo is similar to alloys C276 but performance in a wide range of more oxidising media is significantly enhanced in alloy 59 by increasing Cr to 23%. This alloy also provides a tough Nb-free weld metal for dissimilar welds in superaustenitic and superduplex stainless steel or combinations of these with Ni base alloys.

Nickel alloy Weling wire series: ERNiCrMo-3,ERNiCrMo-4,ERNiCrMo-13,ERNiCrFe-3,ERNiCrFe-7, ERNiCr-3, ERNiCr-7, ERNiCu-7, ERNi-1, ER70S-6.

Standard: Conforms to Certification AWS A5.14 ASME SFA A5.14

Size: 0.8MM / 1.0MM / 1.2MM / 1.6MM / 2.4MM / 3.2MM / 3.8MM / 4.0MM / 5.0MM

Form: MIG(15kgs/spool), TIG(5kgs/box), Strip

### **Chemical Properties**

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CHEMICAL COMPOSITION %										
С	Р	S	Mn	Fe	Si	Ni+Co	Ті	Nb+Ta	Cr	Cu
≤0.1	≤0.03	≤0.015	2.5-3.5	≤3.0	≤0.5	≥67	≤0.75	3.15-4.15	18-22	≤0.50

Ultimate tensile strength (psi)	80,000
Yield strength (0.2% offset) (psi)	40,000
Elongation in 2" (%)	30

### **Typical Welding Parameters**

Diameter		Process	Volt	Amps (flat)	Amps (V/OH)	
inch	(mm)	1100033	Voit	Amps (nat)	Amps (Won)	
0.035	0.9	GMAW	26-29	150-190	Spray Transfer 100% Argon	
0.045	1.2	GMAW	28-32	180-220	Spray Transfer 100% Argon	
1/16	1.6	GMAW	29-33	200-250	Spray Transfer 100% Argon	
1/16	1.6	GTAW	14-18	90-130	100% Argon	
3/32	2.4	GTAW	15-20	120-175	100% Argon	
1/8	3.17	GTAW	15-20	150-220	100% Argon	





