

NOUVE M-NiCrMo-3

ASME SFA-5.14/SFA-5.14M ERNiCrMo-3

UNS No: N06625

APPLICATIONS:

- A solid wire for MIG welding available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions.
- It gives radiographic quality welds. It can be used for welding Ni-Cr-Mo alloys to themselves and for surfacing steel.
- It is also suitable for welding Ni base alloys to steel. It can be used for welding valves, valve seats, impellers, guide points, bushing, bearings, journals, hot working tools like hot shear blades, forging dies, trimming dies, piercing punches etc.

CHEMICAL COMPOSITION OF DEPOSITED METAL (wt%) :

ELEMENTS	AWS SPEC	TYPICAL
Carbon (C)	0.1 Max	0.03
Manganese (Mn)	0.5 Max	0.20
Iron (Fe)	5.0 Max	0.60
Phosphorus (P)	0.020 Max	0.002
Sulphur (S)	0.015 Max	0.008
Silicon (Si)	0.50 Max	0.20
Copper (Cu)	0.50 Max	0.17
Nickel (Ni)	58 Min	62.0
Chromium (Cr)	20.0 - 23.0	22.0
Titanium (Ti)	0.4 Max	0.20
Nb+Ta	3.15 - 4.15	3.5
Molybdenum (Mo)	8.0 - 10.0	9.0
Al	0.40 Max	0.20

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MECHANICAL PROPERTIES OF DEPOSITED METAL:

MECHANICAL TESTS	AWS SPEC	TYPICAL
Tensile Strength	760 MPa Minimum	800 MPa

CVN Impact Energy Test at Temp-196 °C (Joules) : Avg. 126

ADDITIONAL CONDUCTED:

ASTM G 48 Method A test at Temp 22°C-72hrs : Weight loss : 0.188 g/m²

ASTM G 48 Method B test at Temp 22 °C -72hrs : Weight loss : 0.223 g/m²

ASTM G 28 Method A Test : Weight loss : 0.0270 mm/month

RECOMMENDED WELDING TECHNIQUES:

Current/Polarity : DCEP
Shielding Gas : 75% Ar + 25% He

SIZE (mm)	AMPERAGE (A)	VOLTAGE (V)	GAS FLOW RATE (lpm)
0.80	150-190	26-29	20-25
1.00	180-220	28-32	20-25
1.20	200-250	29-33	20-25

PACKING:

SIZE (mm)	WINDING MODE	PACKING MODE	WEIGHT (kgs.)
0.80	SPOOL	CORRUGATED BOX	12.50
1.00	SPOOL	CORRUGATED BOX	12.50
1.20	SPOOL	CORRUGATED BOX	12.50