



MIG NI263

Classification

ISO 18274 : S Ni 7263 (NiCr20Co20Mo6Ti2) AMS : 5966
AFNOR : NCK20D

Description & Applications

Solid wire for GMAW of nickel alloy like NIMONIC 263. High nickel content product resistant to oxidation and high temperature.

Main applications: Aeronautical industry.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Mo	Cu	P	S	Fe
Min	0.04			19.00	5.60				
Max	0.08	0.40	0.60	21.00	6.10	0.20	0.015	0.007	0.70
Type	0.06	0.10	0.20	20.0	5.9	0.01	0.005	0.002	0.40

	Co	Al	Ti	Ag	B	Bi	Pb	Al+Ti	Ni
Min	19.00	0.30	1.90					2.4	47.0
Max	21.00	0.60	2.40	0.0005	0.005	0.0001	0.002	2.8	
Type	20.0	0.50	2.15	0.0002	0.002	0.00003	0.0005	2.65	>47.0

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	-	-	-	-
Max				
Type	-	630	12	-

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	70 - 180	18 - 26	ISO 14175: I1 (100% Ar) I3 (Ar+10-30%He) Z (Ar+He+H+CO ₂) 15-20 l/min
	1.0	80 - 220	18 - 28	
	1.2	150 - 320	22 - 32	
	1.6	220 - 380	24 - 34	

FT En-MI08-200901