MIG NI65

Classification

AWS A5.14 : ERNiFeCr-1 ISO 18274 : S Ni 8065 (NiFe30Cr21Mo3)

Description & Applications

Solid wire for GMAW of Nicklel-Iron-Chromium-Molybden alloys which has a good resistance to oxidizing and reducing agents like sulphuric and phosphoric acid as well as sea water.

Main applications: Chemical and petrochemical industry, ship building, installations for sea water desalination.

Base materials:

UNS	Alloy	DIN	Material N°
N08825	Alloy 825	NiCr21Mo	2.4858

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Mo	Cu	P	S	Fe	Al	Ti	Ni
Min				19.5	2.5	1.5			22.0		0.6	38.0
Max	0.05	0.50	1.0	23.5	3.5	3.0	0.03	0.03		0.20	1.2	46.0
Type	0.02	0.20	0.60	20.5	3.2	1.8	0.01	0.01	Rem.	0.15	0.90	41.0

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	-	-	-	-	-
Max					
Type	350	500	16	-	-

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8 1.0 1.2 1.6	70 - 180 80 - 220 150 - 320 220 - 380	18 - 26 18 - 28 22 - 32 24 - 34	ISO 14175: I1 (100% Ar) I3 (Ar+10-30%He) Z (Ar+He+H+CO_2) 15-20 l/min

FT En-MI15-200901

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