



MIG NIW

Classification

AWS A5.14 : ERNiMo-3
AMS : 5786

ISO 18274 : S Ni 1004 (NiMo25Cr5Fe5)

Description & Applications

Solid wire for GMAW of nickel alloys known as HASTELLOY W®.

Main applications: Aeronautical industry for manufacturing, reparation and maintenance of engines.

® Trade mark of Haynes alloys

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Mo	Cu	P	S	Fe	Co	W	V	Ni
Min				4.00	23.00				4.00				62.0
Max	0.12	1.00	1.00	6.00	26.00	0.50	0.040	0.030	7.00	2.50	1.0	0.60	
Type	0.03	0.20	0.40	5.0	24.0	0.01	0.010	0.005	6.0	0.05	0.03	0.01	>62.0

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	-	-	-	-
Max	-	-	-	-
Type	-	690	-	-

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	

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