MIG NIX

Classification

AWS A5.14 : ERNiCrMo-2
AMS : 5798
ISO 18274 : S Ni 6002 (NiCr21Fe18Mo9)

Description & Applications

Solid wire for GMAW of nickel alloys known as HASTELLOY X®. Best compromise between resistance to oxidation and mechanical characteristics at high temperature.

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	W	Co	B	Ni
Min	0.05			20.50	8.00				17.00	0.20	0.50		44.0
Max	0.15	1.00	1.00	23.00	10.00	0.50	0.040	0.030	20.00	1.00	2.50	0.010	
Type	0.07	0.30	0.60	22.0	8.5	0.25	0.015	0.002	19.0	0.80	1.00	0.003	>44.0

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	-	-	-	-	-
Max					
Type	420	680	23	-	-

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

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