



TIG NI65

Old reference: TIG Ni65

Classification

AWS A5.14 : ERNiFeCr-1

ISO 18274 : S Ni 8065 (NiFe30Cr21Mo3)

Description & Applications

Solid rod for GTAW of Nickel-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	30.0	0.15	0.90	41.0

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
Min	-	-	-
Max	-	-	-
Type	350	475	16

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175: I1 (Ar) : 6-12 l/min Back shielding : I1 (Ar) : 3-6 l/min

FT En-TI052-161213

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr