



# TIG NI90

Old reference: TIG Ni90

## Classification

ISO 18274 : S Ni 7090 (NiCr20Co18Ti3) AMS : 5829

## Description & Applications

Solid rod for GTAW of nickel alloys like NIMONIC 80A and 90.

**Main applications:** Combustion chamber and engine, gas turbine, petrochemical industry, ovens.

## Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Cu	P	S	Fe	Co
Min				18.00					15.00
Max	0.13	1.00	1.00	21.00	0.20	0.020	0.015	1.50	18.00
Type	0.03	0.20	3.2	20.5	2.3	0.01	0.01	1.0	16.0

  

	Al	Ti	Ag	B	Bi	Pb	Zr	Ni
Min	1.00	2.00						50.0
Max	2.00	3.00	0.0005	0.020	0.0001	0.0020	0.15	
Type	1.5	2.5	0.0002	0.005	0.0001	0.001	0.05	>50.0

## All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min	-	-	-	-
Max				
Type	-	-	-	-

## 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 Fr-TI07-200831

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