



## TIG NIW

### Classification

AWS A5.14 : ERNiMo-3  
AMS : 5786

ISO 18274 : S Ni 1004 (NiMo25Cr5Fe5)

### Description & Applications

Solid rod for GTAW 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 <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min	-	-	-	-
Max	-	-	-	-
Type	-	690	-	-

### 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-Ti18-200831

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