TIG NIX

Classification

AWS A5.14 : ERNiCrMo-2
AMS : 5798

ISO 18274 : S Ni 6002 (NiCr21Fe18Mo9)

Description & Applications

Solid rod for GTAW 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	1.0	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	Shielding Gas
TIG = -	ISO 14175: I1 (Ar) : 6-12 l/min Back shielding : I1 (Ar) : 3-6 l/min

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