



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-Molybdenum 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	600	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-TI15-260427

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