

LNT/LNM NiCro 60/20

Ni-base solid wire

Classification

AWS A5.14/A5.14M-97 : ERNiCrMo-3
ISO 18274-01 : S Ni 6625 (NiCr22Mo9Nb)

General description

Solid wire for welding of nickel alloys
Extreme resistance to various corrosion forms
High chromium and molybdenum content

Shielding gases (acc. EN 439)

GTAW/GMAW	I1	Inert gas Ar (100%)
	I3	Inert gas Ar+ >0-95% He

Approvals

	TÜV
GTAW	+

Chemical composition (w%), typical, wire / rod

C	Mn	Si	Ni	Cr	Mo	Nb	Fe
0.02	0.06	0.07	64	21.9	9	3.5	1.7

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
							+20°C	-196°C
Typical values	GTAW	I1	AW	520	800	35	130	100
	GMAW	I1	AW	520	770	34	80	60

Materials to be welded

Steel grades	BS 1501 3076	DIN 17444/17465 SEW 595/680	W.Nr.	ASTM / ACI	UNS
NiCrMo-steel type 625 and welding dissimilar high NiCrMo-steels for corrosion and heat resisting purposes	NA 15	X10NiCrAlTi32 20 NiCr22Mo	1.4876 2.4605	Alloy800/800H	N08800/-10
	NA 14	NiCr15Fe NiCr22Mo9Nb	2.4816 2.4856	B168-Alloy 600 B443-Alloy 625	N06600 N06625
	NA 16	NiCr21Mo X1NiCrMoCuN25 20 6	2.4858 1.4529	B424-Alloy 825	N08825
		NiCr20Ti	2.4951	Alloy 75	N06075
		NiCr20TiA1	2.4952	Alloy 80A	N07080
		NiCr20CuMo	2.4660	Alloy 20	N08020
		X1NiCrMoCu25 20 5	1.4539		
		X2NiCrAlTi32 20	1.4558	Alloy 800L	N08800
		G-X10NiCrNb32 20	1.4859		
		12Ni9	1.5680	A333-5%Ni	
Low alloyed steel	GS-10Ni19	1.5681	5%Ni cast		
	G-X8Ni9	1.5662	A353-9%Ni cast		K81340
	10Ni14	1.5637			

Packaging

Process	Unit	Sizes (mm)							
		0.8	1.0	1.2	1.6	2.0	2.4	3.2	
GTAW	2 and 10 kg tube					X	X	X	X
GMAW	5 kg spool S200			X					
	15 kg spool BS300	X	X	X					

Other sizes and packaging on request

LNT/LNM NiCro 60/20: rev. EN 15