

LNT/LNM NiCrMo 60/16

Ni-base solid wire

Classification

AWS A5.14/A5.14M-97 : ERNiCrMo-4

ISO 18274-04 : S Ni 6276 (NiCr15Mo16Fe6W4)

General description

Solid wire for welding CrMoW-alloyed nickel alloys (e.g. Alloy C276)

Depending on the corrosion requirements also applicable for welding C-22 and C-4

Extreme resistance to corrosion environments containing sulphuric acid and chlorides

Applicable for surfacing in high temperature applications (up to 1200°C)

Shielding gases (acc. EN 439)

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

Approvals

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

C	Mn	Si	Ni	Cr	Mo	W	Fe
0.015	0.5	0.04	bal	15.5	16.0	3.6	5.8

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact ISO-V (J) +20 °C
Typical values	GTAW	I1	AW	410	720	27	100
	GMAW	I1	AW	400	700	25	90

Materials to be welded

Steel grades	DIN/EN	Mat. Nr.	ASTM/ACI	UNS
Ni Base high CrMo	NiMo 16Cr15W	2.4819	C-276	N10276
steel for high corrosion environments	NiCr21Mo14W	2.4602	C-22	N06022
	NiMo 16Cr16Ti	2.4610	C-4	N06455

- LNT/LNM NiCrMo 60/16 is developed for welding C-276 material

- Can also be applied for welding C-22 and C-4, depending on the corrosion requirements

Packaging

Process	Unit	Sizes (mm)						
		1.0	1.2	1.6	2.0	2.4	3.2	
GTAW	2 kg tube			X	X	X	X	
GMAW	15 kg spool B301	X	X					

LNT/LNM NiCrMo 60/16 : rev. EN

LINCOLN
ELECTRIC