

NICROMIG 600

MIG/MAG Wires [GMAW]

Nickel alloys

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 18274-A : S Ni 6082 (NiCr20Mn3Nb) DIN 1736 : SG NiCr20 Nb AWS A-5.14 : ER NiCr-3 W.Nr. : 2.4806	CE, TUV	Power generation industry Constructions & Engineering Petrochemical and chemical industry

- Solid wire used for welding nickel alloy steels with austenitic steels, nickel alloys with ferritic steels and austenitic steels with ferritic steels, operating at temperatures exceeding 300°C, and for dissimilar joints.
- Recommended interpass temperature 150°C.

Application

Chemical industry: heaters, condensers, trays. Heat treatment industry: muffs, retorts, baskets, furnace accessories. Nuclear, aviation industry. Reactor vessels and heat exchanger tubes used in the production of vinyl chloride. Process equipment used in the production of chlorinated and fluorinated hydrocarbons. Seals, fans and retort furnace equipment. Roller furnaces and radiant tubes, especially in coal nitriding processes. Linings for barges and road tankers. Production of gasoline stabilizers, phenolic condensers, production of soap, vessels for the production of fatty acids. Industrial chemical evaporators, industrial acid and alkali equipment, afterburner parts and other components used in high temperature, vacuum furnace equipment, alkaline cookers, catalyst regenerators in chemical production. Consumable material for welding dedicated alloys, cryo steel, for welding dissimilar joints, surfacing.

Base material

DIN	W.Nr.	DIN	W.Nr.
NiCr20Ti	2.4630	NiCr20Ti	2.4951
NiCr21TiAl	2.4631	12Ni14	1.5637
NiCr15Fe7TiAl	2.4669	X8Ni9	1.5662
NiCr15Fe	2.4816	12Ni19	1.5680
LC-NiCr15Fe	2.4817	X12CrNi189	1.6900
NiCr23Fe	2.4851	GX8CrNi1810	1.6901
NiCr6015	2.4867	X10CrNiTi1810	1.6903
NiCr8020	2.4869	X5CrNi1810	1.6906
NiCr10	2.4870		

Typical chemical composition %

C	Si	Mn	Cr	Ni	Nb	Fe
0,02	0,20	2,8	19,5	>67	2,5	<2,0

Typical mechanical properties

Yield strength Re [N/mm2]	>380
Tensile strength Rm [N/mm2]	>620
Elongation A5 [%]	>35
Impact energy Kv [J]	>90J (20°C) /
Shielding gases acc. to EN ISO 14175	I1 - Ar / I3 - Ar + >0-95% He /

Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Weight of packet [kg]
0,8	80-130		15,0

1,0	120-190	16-29	15,0
1,2	180-250	18-29	15,0
1,6	250-320	22-32	15,0

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl