MIG NI686

Classification

AWS A5.14 : ERNiCrMo-14

Description & Applications

Nickel alloy for IG welding of UNS N06686 and similar compositions. Could be used for overmatching such as C-276 alloy.

Main applications: Overlay on carbon and low alloys steels

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	Fe	W	Ti	W	Al	P	S	Other	Ni
< 0.01	< 0.08	0.1	21.0	16.0	0.2	3.7	<0.25	3.7	<0.5	<0.02	<0.02	< 0.5	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
-	760	30

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	1.2 1.6	160-200 180-260	24-28 24-28	ISO 14175: I1 (Ar) I3 (Ar/He) 18-20 l/min

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